Aero Design Ltd.

Work Order Control Sheet

Work Order#: 2017-104 **Date Opened:** 16 June 2017 **Title:** Fabrication

Aircraft OEM: Airbus **Aircraft Model:** AS350/355 **Product Type:** Mounting Beam **Product Model:** AFT RH **Quantity:** 36

Work Order Contents

	Initial or N/A
Work Order/Build Sheets (Procedures Provided)	JC
Additional Work Sheets (Standard Practice)	N/A
Drawings (See List Below)	JC
Parts Distribution Sheet	JC
Sub Component Tags	N/A
Completed Certification (Original)	JC
Time Sheet (R&D)	N/A
Notes	N/A

Build Sheet Contents

	Initial or N/A
Tasks Initialled	JC
Dual Inspections Initialled	JC

Drawing List

Drawing #	Rev #	Description	Initial or N/A
78633	1	AFT Beam Fabrication	JC

Component Completion

	As Instructed
Quantity Complete on This Work Order	36
Quantity Incomplete on This Work Order	0
Further Processing Required Before Release	N/A
Release to Stock as Components	N/A
Outside Processing	N/A

Certification

	Initial or N/A
Form One Completed	JC
Serviceable (Green) Tag Completed	N/A
In Process (Yellow) Tag Completed	JC
Unserviceable (Red) Tag Completed	N/A
White Tracking Tag Completed	N/A
Parts Placed in Stores for Distribution	JC

Additional Documentation

	Initial or N/A
Non-Conformance Report Required	N/A
Service Difficulty Report Required	N/A

Billing

	Initial or N/A
Local (Aero Design)	JC
Research and Development	N/A
Third Party	N/A

Traveller

Work performed by:	Print: J. CLARKE	Sign: JC	SCA: AD02	Date: 16 OCT 2018
ICC / Dual Inspection preformed by:	Print: J. RENÉ	Sign: JR	SCA: AD01	Date: 16 OCT 2018
Work Order closed by:	Print: J. CLARKE	Sign: JC	SCA: AD02	Date: 16 AUG 2019

Complete 31-35

MOUNTING BEAM FABRICATION – 78633

General

These instructions apply to mounting beams 78633-01 (aft) for AS350/AS355 cargo baskets. Refer to the following drawings, at the current revision, for dimensions and details:

78633 – Aft Beam

Work Order: 2017-104 RH

Batch Quantity: 36
(5 max, use additional sheets for more)

Date Open: 16 June 2017

Complete (initial or SCA #)

#1	#2	#3	#4	#5
AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02

1. Beam Fabrication – 1x2 tubes
   a. Cut 1 x 2 x 0.065 material as indicated on drawings.
      i. 78633-02 – 24.44"
   b. Cut 1 x 2 x 0.120 material @ 16.38" long for upper guide (10).
   c. Record material PO on attached material list.
   d. De-burr cut ends using a sanding disc on a die-grinder. De-burr inside with de-burring tool.
   e. Remove writing on tubes with acetone.
   f. Tag in-progress parts and place on in-progress shelf in machine shop for CNC machining of keyways, slots, and bushing holes.

AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02

2. CNC Machining
   a. Run CNC programs to machine slots and holes in 78633-02 tubes.
   b. Run CNC programs to machine blanks for upper guides.
   c. De-burr slots and holes.
   d. Tag in-progress parts and place on in-progress shelf in welding shop for welding.

AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02

3. Beam Fabrication – Components
   Note: Some components are used for many different beams and are made in batches on separate component work orders. Check stock before making components.
   a. Shear caps from 0.025" sheet: 78633-06
   b. Cut 78633-03 guides from 1x1/8 stock.
   c. Cut and turn 78630-04 bushings from 3/8 x 0.065 tube.
   d. Cut 78633-04 upper guides from blanks machined in step 2.b.
   e. Cut 78633-05 stop brackets from 0.75 x 0.065 tube.
   f. Cut 82735-03 step tubes from 1.0 x 0.035 tube.
   g. Punch 82735-06 step cap from 0.050 sheet, 1.25 diameter. Flatten on steel table with a hammer.
   h. Record component POs / WOs on attached material list and place on in-progress shelf in welding shop.

Complete (initial or SCA #)

	#1	#2	#3	#4	#5
4. Beam Welding	AD 73-04 05	AD 73-04 05	AD 73-04 05	AD 73-04 05	AD 73-04 05
5. Beam Straightening	AD 73-04 10	AD 73-04 10	AD 73-04 10	AD 73-04 10	AD 73-04 10
6. CNC Machining	AD 73-04 10	AD 73-04 10	AD 73-04 10	AD 73-04 10	AD 73-04 10
7. Beam Welding	AD 73-04 05	AD 73-04 05	AD 73-04 05	AD 73-04 05	AD 73-04 05

4. Beam Welding
   a. TIG weld 78633-03 guide, 4 places, and 78633-04 upper guide into 78633-02 tubes using ER308L rod.
      i. Clamp two beams back to back with 1/8" spacer in middle to pre-stress beams prior to welding.
   b. Record component and welding rod POs / WOs on attached material list.
   c. Tag in-progress parts for straightening.

5. Beam Straightening

   Welding on one side of the beam causes the beam to curve. Beams must be straight prior to machining slots.
   a. Set beam on blocks as far apart as possible on hydraulic press.
   b. Use a 2" block to distribute press loads.
   c. Gradually work up to pressure required to make beam straight, usually about 800 psi is required. The same pressure generally works for beams from the same batch.
   d. Check for straight with a straight edge on back of tube.
   e. 78633-01 aft beams may require straightening on side as well, repeat steps a-d on side, using about 600 psi.
   f. Tag in-progress parts and place on in-progress shelf in CNC shop for machining.

6. CNC Machining
   a. Run CNC programs to machine keyways and slots in 78633-02 tubes with guides welded in place, after straightening.
   b. De-burr keyways and slots.
   c. Tag in-progress parts and place on in-progress shelf in welding shop for welding.

7. Beam Welding
   a. Peg step: TIG weld 82735-06 cap to 82735-03 tube using jig to align cap to tube.
   b. TIG weld 78633-04 bushings into 78633-02 tube using ER308L rod, four places per tube, both sides.
   c. TIG weld 78633-05 stop bracket to 78633-02 tube using ER308L rod, four places per tube, both sides. Use jig to align stop brackets for height and position.
   d. TIG weld 78633-06 cap to 78633-02 tube.
   e. TIG weld step tube assembly from a. to back of 78633-02 tube using jig for alignment. Weld around step tube as far as possible, then close out tube by flattening protruding edge of step tube with a hammer. Complete weld after flattening.
   f. Record component and welding rod POs / WOs on attached material list.
   g. Tag in-progress parts and place on in-progress shelf in welding shop for straightening.

Complete
(initial or SCA #)

	#1	#2	#3	#4	#5
8. Beam Finishing	AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02
9. Final Inspection	AD 73-01 01	AD 73-01 01	dk	dk	dk
10. Powder Coating	AD 73-04 02	AD 73-04 02			
11. Final Assembly	AD 73-04 02	AD 73-04 02	AD 73-04 02 ENTERED IN ERROR AD 73-04 02	AD 73-04 02	AD 73-04 02

8. Beam Finishing

Welding on one side of the beam causes the beam to curve. Beams must be straight prior to powder coating.

a. Set beam on blocks on hydraulic press. Straightening in sections may be required depending on severity of curve.
b. Use a 2" block to distribute press loads.
c. Gradually work up to pressure required to make beam straight, usually about 800 psi is required. The same pressure generally works for beams from the same batch.
d. Check for straight with a straight edge on back of tube.
e. 78633-01 aft beams may require straightening on side as well, repeat steps a-d on side, using about 600 psi.
f. Drill out bushings to F (0.257"), four places per beam, on drill press.
g. Break sharp edges on stops and flatten bushing locations using sanding disc on die-grinder.
h. Tag in-progress parts and place on in-progress shelf in welding shop for inspection.

9. Final Inspection

To be completed by a different person than the previous steps.

a. Inspect beams 78633-01-XX for conformity to drawings.
b. Tag in-progress parts ready for powder coating.

10. Powder Coating

a. Parts are to be powder coated in accordance with commercial practices.
b. Record powder coating PO.
c. Inspect powder coating on receiving.
d. Tag in-progress parts ready for final assembly.

11. Final Assembly

To be completed after powder coating.

a. Prepare step tube for grip tape by rubbing top surface with scotch-brite.
b. Adhere 1" 3M Safety-Walk grip tape to top surface of step tube.
c. Adhere P/N placard to back surface of beam.
d. Ensure AN4 bolt can be inserted through bushings.
e. Green tag complete beam assembly and place into stock.

Complete 36

MOUNTING BEAM FABRICATION – 78633

General

These instructions apply to mounting beams 78633-01 (aft) for AS350/AS355 cargo baskets. Refer to the following drawings, at the current revision, for dimensions and details:

78633 – Aft Beam

Work Order: 2017-104 RH

Batch Quantity: 36
(5 max, use additional sheets for more)

Date Open: 16 June 2017

Complete (initial or SCA #)

	#1	#2	#3	#4	#5
1. Beam Fabrication – 1x2 tubes	N/A	N/A	N/A	N/A	AD 73-04 02
2. CNC Machining	N/A	N/A	N/A	N/A	AD 73-04 02
3. Beam Fabrication – Components	N/A	N/A	N/A	N/A	AD 73-04 02

1. Beam Fabrication – 1x2 tubes
   a. Cut 1 x 2 x 0.065 material as indicated on drawings.
      i. 78633-02 – 24.44"
   b. Cut 1 x 2 x 0.120 material @ 16.38" long for upper guide (10).
   c. Record material PO on attached material list.
   d. De-burr cut ends using a sanding disc on a die-grinder. De-burr inside with de-burring tool.
   e. Remove writing on tubes with acetone.
   f. Tag in-progress parts and place on in-progress shelf in machine shop for CNC machining of keyways, slots, and bushing holes.

2. CNC Machining
   a. Run CNC programs to machine slots and holes in 78633-02 tubes.
   b. Run CNC programs to machine blanks for upper guides.
   c. De-burr slots and holes.
   d. Tag in-progress parts and place on in-progress shelf in welding shop for welding.

3. Beam Fabrication – Components
   Note: Some components are used for many different beams and are made in batches on separate component work orders. Check stock before making components.
   a. Shear caps from 0.025" sheet: 78633-06
   b. Cut 78633-03 guides from 1x1/8 stock.
   c. Cut and turn 78630-04 bushings from 3/8 x 0.065 tube.
   d. Cut 78633-04 upper guides from blanks machined in step 2.b.
   e. Cut 78633-05 stop brackets from 0.75 x 0.065 tube.
   f. Cut 82735-03 step tubes from 1.0 x 0.035 tube.
   g. Punch 82735-06 step cap from 0.050 sheet, 1.25 diameter. Flatten on steel table with a hammer.
   h. Record component POs / WOs on attached material list and place on in-progress shelf in welding shop.

	Complete (initial or SCA #)				
	#1	#2	#3	#4	#5
4. Beam Welding	N/A	N/A	N/A	N/A	AD 73-04 05

a. TIG weld 78633-03 guide, 4 places, and 78633-04 upper guide into 78633-02 tubes using ER308L rod.
   i. Clamp two beams back to back with 1/8" spacer in middle to pre-stress beams prior to welding.
b. Record component and welding rod POs / WOs on attached material list.
c. Tag in-progress parts for straightening.

5. Beam Straightening	N/A	N/A	N/A	N/A	AD 73-04 10

Welding on one side of the beam causes the beam to curve. Beams must be straight prior to machining slots.

a. Set beam on blocks as far apart as possible on hydraulic press.
b. Use a 2" block to distribute press loads.
c. Gradually work up to pressure required to make beam straight, usually about 800 psi is required. The same pressure generally works for beams from the same batch.
d. Check for straight with a straight edge on back of tube.
e. 78633-01 aft beams may require straightening on side as well, repeat steps a-d on side, using about 600 psi.
f. Tag in-progress parts and place on in-progress shelf in CNC shop for machining.

6. CNC Machining	N/A	N/A	N/A	N/A	AD 73-04 10

a. Run CNC programs to machine keyways and slots in 78633-02 tubes with guides welded in place, after straightening.
b. De-burr keyways and slots.
c. Tag in-progress parts and place on in-progress shelf in welding shop for welding.

7. Beam Welding	N/A	N/A	N/A	N/A	AD 73-04 05

a. Peg step: TIG weld 82735-06 cap to 82735-03 tube using jig to align cap to tube.
b. TIG weld 78633-04 bushings into 78633-02 tube using ER308L rod, four places per tube, both sides.
c. TIG weld 78633-05 stop bracket to 78633-02 tube using ER308L rod, four places per tube, both sides. Use jig to align stop brackets for height and position.
d. TIG weld 78633-06 cap to 78633-02 tube.
e. TIG weld step tube assembly from a. to back of 78633-02 tube using jig for alignment. Weld around step tube as far as possible, then close out tube by flattening protruding edge of step tube with a hammer. Complete weld after flattening.
f. Record component and welding rod POs / WOs on attached material list.
g. Tag in-progress parts and place on in-progress shelf in welding shop for straightening.

	Complete (initial or SCA #)				
	#1	#2	#3	#4	#5
8. Beam Finishing	N/A	N/A	N/A	N/A	AD 73-04 02
9. Final Inspection	N/A	N/A	N/A	N/A	AD 73-04 01
10. Powder Coating	N/A	N/A	N/A	N/A	AD 73-04 02
11. Final Assembly	N/A	N/A	N/A	N/A	AD 73-04 02

8. Beam Finishing

Welding on one side of the beam causes the beam to curve. Beams must be straight prior to powder coating.

a. Set beam on blocks on hydraulic press. Straightening in sections may be required depending on severity of curve.
b. Use a 2" block to distribute press loads.
c. Gradually work up to pressure required to make beam straight, usually about 800 psi is required. The same pressure generally works for beams from the same batch.
d. Check for straight with a straight edge on back of tube.
e. 78633-01 aft beams may require straightening on side as well, repeat steps a-d on side, using about 600 psi.
f. Drill out bushings to F (0.257"), four places per beam, on drill press.
g. Break sharp edges on stops and flatten bushing locations using sanding disc on die-grinder.
h. Tag in-progress parts and place on in-progress shelf in welding shop for inspection.

9. Final Inspection

To be completed by a different person than the previous steps.

a. Inspect beams 78633-01-XX for conformity to drawings.
b. Tag in-progress parts ready for powder coating.

PAINT QC.

10. Powder Coating

a. Parts are to be powder coated in accordance with commercial practices.
b. Record powder coating PO.
c. Inspect powder coating on receiving.
d. Tag in-progress parts ready for final assembly.

11. Final Assembly

To be completed after powder coating.

a. Prepare step tube for grip tape by rubbing top surface with scotch-brite.
b. Adhere 1" 3M Safety-Walk grip tape to top surface of step tube.
c. Adhere P/N placard to back surface of beam.
d. Ensure AN4 bolt can be inserted through bushings.
e. Green tag complete beam assembly and place into stock.

complete 1-5

MOUNTING BEAM FABRICATION – 78633

General

These instructions apply to mounting beams 78633-01 (aft) for AS350/AS355 cargo baskets. Refer to the following drawings, at the current revision, for dimensions and details:

78633 – Aft Beam

Work Order: 2017-104 RH

Batch Quantity: 36
(5 max, use additional sheets for more)

Complete
(initial or SCA #)

Date Open: 16 JUNE 2017

#1	#2	#3	#4	#5
AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02

1. Beam Fabrication – 1x2 tubes
   a. Cut 1 x 2 x 0.065 material as indicated on drawings.
      i. 78633-02 – 24.44"
   b. Cut 1 x 2 x 0.120 material @ 16.38" long for upper guide (10).
   c. Record material PO on attached material list.
   d. De-burr cut ends using a sanding disc on a die-grinder. De-burr inside with de-burring tool.
   e. Remove writing on tubes with acetone.
   f. Tag in-progress parts and place on in-progress shelf in machine shop for CNC machining of keyways, slots, and bushing holes.

AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02

2. CNC Machining
   a. Run CNC programs to machine slots and holes in 78633-02 tubes.
   b. Run CNC programs to machine blanks for upper guides.
   c. De-burr slots and holes.
   d. Tag in-progress parts and place on in-progress shelf in welding shop for welding.

AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02

3. Beam Fabrication – Components
   Note: Some components are used for many different beams and are made in batches on separate component work orders. Check stock before making components.
   a. Shear caps from 0.025" sheet: 78633-06
   b. Cut 78633-03 guides from 1x1/8 stock.
   c. Cut and turn 78630-04 bushings from 3/8 x 0.065 tube.
   d. Cut 78633-04 upper guides from blanks machined in step 2.b.
   e. Cut 78633-05 stop brackets from 0.75 x 0.065 tube.
   f. Cut 82735-03 step tubes from 1.0 x 0.035 tube.
   g. Punch 82735-06 step cap from 0.050 sheet, 1.25 diameter. Flatten on steel table with a hammer.
   h. Record component POs / WOs on attached material list and place on in-progress shelf in welding shop.

Complete
(initial or SCA #)

#1	#2	#3	#4	#5
AD 73-04 05	AD 73-04 05	AD 73-04 05	AD 73-04 05	AD 73-04 05

4. Beam Welding
    a. TIG weld 78633-03 guide, 4 places, and 78633-04 upper guide into 78633-02 tubes using ER308L rod.
        i. Clamp two beams back to back with 1/8" spacer in middle to pre-stress beams prior to welding.
    b. Record component and welding rod POs / WOs on attached material list.
    c. Tag in-progress parts for straightening.

AD 73-04 10	AD 73-04 10	AD 73-04 10	AD 73-04 10	AD 73-04 10

5. Beam Straightening
    Welding on one side of the beam causes the beam to curve. Beams must be straight prior to machining slots.
    a. Set beam on blocks as far apart as possible on hydraulic press.
    b. Use a 2" block to distribute press loads.
    c. Gradually work up to pressure required to make beam straight, usually about 800 psi is required. The same pressure generally works for beams from the same batch.
    d. Check for straight with a straight edge on back of tube.
    e. 78633-01 aft beams may require straightening on side as well, repeat steps a-d on side, using about 600 psi.
    f. Tag in-progress parts and place on in-progress shelf in CNC shop for machining.

AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02

6. CNC Machining
    a. Run CNC programs to machine keyways and slots in 78633-02 tubes with guides welded in place, after straightening.
    b. De-burr keyways and slots.
    c. Tag in-progress parts and place on in-progress shelf in welding shop for welding.

AD 73-04 05	AD 73-04 05	AD 73-04 05	AD 73-04 05	AD 73-04 05

7. Beam Welding
    a. Peg step: TIG weld 82735-06 cap to 82735-03 tube using jig to align cap to tube.
    b. TIG weld 78633-04 bushings into 78633-02 tube using ER308L rod, four places per tube, both sides.
    c. TIG weld 78633-05 stop bracket to 78633-02 tube using ER308L rod, four places per tube, both sides. Use jig to align stop brackets for height and position.
    d. TIG weld 78633-06 cap to 78633-02 tube.
    e. TIG weld step tube assembly from a. to back of 78633-02 tube using jig for alignment. Weld around step tube as far as possible, then close out tube by flattening protruding edge of step tube with a hammer. Complete weld after flattening.
    f. Record component and welding rod POs / WOs on attached material list.
    g. Tag in-progress parts and place on in-progress shelf in welding shop for straightening.

Complete
(initial or SCA #)

	#1	#2	#3	#4	#5
8. Beam Finishing	AD 73-04 10	73-04 10	73-04 10	AD 73-04 10	AD 73-04 10

Welding on one side of the beam causes the beam to curve. Beams must be straight prior to powder coating.

a. Set beam on blocks on hydraulic press. Straightening in sections may be required depending on severity of curve.
b. Use a 2" block to distribute press loads.
c. Gradually work up to pressure required to make beam straight, usually about 800 psi is required. The same pressure generally works for beams from the same batch.
d. Check for straight with a straight edge on back of tube.
e. 78633-01 aft beams may require straightening on side as well, repeat steps a-d on side, using about 600 psi.
f. Drill out bushings to F (0.257"), four places per beam, on drill press.
g. Break sharp edges on stops and flatten bushing locations using sanding disc on die-grinder.
h. Tag in-progress parts and place on in-progress shelf in welding shop for inspection.

9. Final Inspection	AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02

To be completed by a different person than the previous steps.

a. Inspect beams 78633-01-XX for conformity to drawings.
b. Tag in-progress parts ready for powder coating.

10. Powder Coating	AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02

a. Parts are to be powder coated in accordance with commercial practices.
b. Record powder coating PO.
c. Inspect powder coating on receiving.
d. Tag in-progress parts ready for final assembly.

painted

11. Final Assembly	73-04 02	AD 73-04 02	AD 73-04	AD 73-04 02	AD 73-04 02

To be completed after powder coating.

a. Prepare step tube for grip tape by rubbing top surface with scotch-brite.
b. Adhere 1" 3M Safety-Walk grip tape to top surface of step tube.
c. Adhere P/N placard to back surface of beam.
d. Ensure AN4 bolt can be inserted through bushings.
e. Green tag complete beam assembly and place into stock.

Complete 6-10

MOUNTING BEAM FABRICATION – 78633

General

These instructions apply to mounting beams 78633-01 (aft) for AS350/AS355 cargo baskets. Refer to the following drawings, at the current revision, for dimensions and details:

78633 – Aft Beam

Work Order: 2017-104 RH

Date Open: 16 June 2017

Batch Quantity: 36
(5 max, use additional sheets for more)

Complete
(initial or SCA #)

#1	#2	#3	#4	#5
AO 73-04 02	AO 73-04 02	AO 73-04 02	AO 73-04 02	AO 73-04 02

1. Beam Fabrication – 1x2 tubes
   a. Cut 1 x 2 x 0.065 material as indicated on drawings.
      i. 78633-02 – 24.44"
   b. Cut 1 x 2 x 0.120 material @ 16.38" long for upper guide (10).
   c. Record material PO on attached material list.
   d. De-burr cut ends using a sanding disc on a die-grinder. De-burr inside with de-burring tool.
   e. Remove writing on tubes with acetone.
   f. Tag in-progress parts and place on in-progress shelf in machine shop for CNC machining of keyways, slots, and bushing holes.

AO 73-04 02	AO 73-04 02	AO 73-04 02	AO 73-04 02	AO 73-04 02

2. CNC Machining
   a. Run CNC programs to machine slots and holes in 78633-02 tubes.
   b. Run CNC programs to machine blanks for upper guides.
   c. De-burr slots and holes.
   d. Tag in-progress parts and place on in-progress shelf in welding shop for welding.

AO 73-04 02	AO 73-04 02	AO 73-04 02	AO 73-04 02	AO 73-04 02

3. Beam Fabrication – Components
   Note: Some components are used for many different beams and are made in batches on separate component work orders. Check stock before making components.
   a. Shear caps from 0.025" sheet: 78633-06
   b. Cut 78633-03 guides from 1x1/8 stock.
   c. Cut and turn 78630-04 bushings from 3/8 x 0.065 tube.
   d. Cut 78633-04 upper guides from blanks machined in step 2.b.
   e. Cut 78633-05 stop brackets from 0.75 x 0.065 tube.
   f. Cut 82735-03 step tubes from 1.0 x 0.035 tube.
   g. Punch 82735-06 step cap from 0.050 sheet, 1.25 diameter. Flatten on steel table with a hammer.
   h. Record component POs / WOs on attached material list and place on in-progress shelf in welding shop.

Complete
(initial or SCA #)

	#1	#2	#3	#4	#5
4. Beam Welding	AD 73-04 05	AD 73-04 05	73-04 05	73-04 05	AD 73-04 05
5. Beam Straightening	AD 73-04 10	AD 73-04 10	AD 73-04 10	AD 73-04 10	AD 73-04 10
6. CNC Machining	AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02
7. Beam Welding	AD 73-04 05	AD 73-04 05	AD 73-04 05	AD 73-04 05	AD 73-0- 05

4. Beam Welding
   a. TIG weld 78633-03 guide, 4 places, and 78633-04 upper guide into 78633-02 tubes using ER308L rod.
      i. Clamp two beams back to back with 1/8" spacer in middle to pre-stress beams prior to welding.
   b. Record component and welding rod POs / WOs on attached material list.
   c. Tag in-progress parts for straightening.

5. Beam Straightening

   Welding on one side of the beam causes the beam to curve. Beams must be straight prior to machining slots.
   a. Set beam on blocks as far apart as possible on hydraulic press.
   b. Use a 2" block to distribute press loads.
   c. Gradually work up to pressure required to make beam straight, usually about 800 psi is required. The same pressure generally works for beams from the same batch.
   d. Check for straight with a straight edge on back of tube.
   e. 78633-01 aft beams may require straightening on side as well, repeat steps a-d on side, using about 600 psi.
   f. Tag in-progress parts and place on in-progress shelf in CNC shop for machining.

6. CNC Machining
   a. Run CNC programs to machine keyways and slots in 78633-02 tubes with guides welded in place, after straightening.
   b. De-burr keyways and slots.
   c. Tag in-progress parts and place on in-progress shelf in welding shop for welding.

7. Beam Welding
   a. Peg step: TIG weld 82735-06 cap to 82735-03 tube using jig to align cap to tube.
   b. TIG weld 78633-04 bushings into 78633-02 tube using ER308L rod, four places per tube, both sides.
   c. TIG weld 78633-05 stop bracket to 78633-02 tube using ER308L rod, four places per tube, both sides. Use jig to align stop brackets for height and position.
   d. TIG weld 78633-06 cap to 78633-02 tube.
   e. TIG weld step tube assembly from a. to back of 78633-02 tube using jig for alignment. Weld around step tube as far as possible, then close out tube by flattening protruding edge of step tube with a hammer. Complete weld after flattening.
   f. Record component and welding rod POs / WOs on attached material list.
   g. Tag in-progress parts and place on in-progress shelf in welding shop for straightening.

Complete
(initial or SCA #)

	#1	#2	#3	#4	#5
8. Beam Finishing	AD 73-04 10	AD 73-04 10	AD 73-04 10	AD 73-04 10	AD 73-04 10

Welding on one side of the beam causes the beam to curve. Beams must be straight prior to powder coating.

a. Set beam on blocks on hydraulic press. Straightening in sections may be required depending on severity of curve.
b. Use a 2" block to distribute press loads.
c. Gradually work up to pressure required to make beam straight, usually about 800 psi is required. The same pressure generally works for beams from the same batch.
d. Check for straight with a straight edge on back of tube.
e. 78633-01 aft beams may require straightening on side as well, repeat steps a-d on side, using about 600 psi.
f. Drill out bushings to F (0.257"), four places per beam, on drill press.
g. Break sharp edges on stops and flatten bushing locations using sanding disc on die-grinder.
h. Tag in-progress parts and place on in-progress shelf in welding shop for inspection.

9. Final Inspection	AR	AR	AR	AR	AR

To be completed by a different person than the previous steps.

a. Inspect beams 78633-01-XX for conformity to drawings.
b. Tag in-progress parts ready for powder coating.

10. Powder Coating	CMB	CMB	CMB	CMB	CMB

a. Parts are to be powder coated in accordance with commercial practices.
b. Record powder coating PO.
c. Inspect powder coating on receiving.
d. Tag in-progress parts ready for final assembly.

11. Final Assembly	AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02

To be completed after powder coating.

a. Prepare step tube for grip tape by rubbing top surface with scotch-brite.
b. Adhere 1" 3M Safety-Walk grip tape to top surface of step tube.
c. Adhere P/N placard to back surface of beam.
d. Ensure AN4 bolt can be inserted through bushings.
e. Green tag complete beam assembly and place into stock.

Complete 11-15

MOUNTING BEAM FABRICATION – 78633

General

These instructions apply to mounting beams 78633-01 (aft) for AS350/AS355 cargo baskets. Refer to the following drawings, at the current revision, for dimensions and details:

78633 – Aft Beam

Work Order: 2017-104 RH

Date Open: 16 June 2017

Batch Quantity: 36
(5 max, use additional sheets for more)

	#1	#2	#3	#4	#5
Complete (initial or SCA #)	AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02

1. Beam Fabrication – 1x2 tubes
   a. Cut 1 x 2 x 0.065 material as indicated on drawings.
      i. 78633-02 – 24.44"
   b. Cut 1 x 2 x 0.120 material @ 16.38" long for upper guide (10).
   c. Record material PO on attached material list.
   d. De-burr cut ends using a sanding disc on a die-grinder. De-burr inside with de-burring tool.
   e. Remove writing on tubes with acetone.
   f. Tag in-progress parts and place on in-progress shelf in machine shop for CNC machining of keyways, slots, and bushing holes.

	AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02

2. CNC Machining
   a. Run CNC programs to machine slots and holes in 78633-02 tubes.
   b. Run CNC programs to machine blanks for upper guides.
   c. De-burr slots and holes.
   d. Tag in-progress parts and place on in-progress shelf in welding shop for welding.

	AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02

3. Beam Fabrication – Components
   Note: Some components are used for many different beams and are made in batches on separate component work orders. Check stock before making components.
   a. Shear caps from 0.025" sheet: 78633-06
   b. Cut 78633-03 guides from 1x1/8 stock.
   c. Cut and turn 78630-04 bushings from 3/8 x 0.065 tube.
   d. Cut 78633-04 upper guides from blanks machined in step 2.b.
   e. Cut 78633-05 stop brackets from 0.75 x 0.065 tube.
   f. Cut 82735-03 step tubes from 1.0 x 0.035 tube.
   g. Punch 82735-06 step cap from 0.050 sheet, 1.25 diameter. Flatten on steel table with a hammer.
   h. Record component POs / WOs on attached material list and place on in-progress shelf in welding shop.

Complete
(initial or SCA #)

	#1	#2	#3	#4	#5
4. Beam Welding	AD 73-04 05	AD 73-04 05	AD 73-04 05	AD 73-04 05	AD 73-04 05
5. Beam Straightening	AD 73-04 10	AD 73-04 10	AD 73-04 10	AD 73-04 10	AD 73-04 10
6. CNC Machining	AD 73-04 02	AD 73-04 02	AD 73-04 10	AD 73-04 10	AD 73-04 10
7. Beam Welding	AD 73-04 05	AD 73-04 05	AD 73-04 06	AD 73-04 05	AD 73-04 05

a. TIG weld 78633-03 guide, 4 places, and 78633-04 upper guide into 78633-02 tubes using ER308L rod.
    i. Clamp two beams back to back with 1/8" spacer in middle to pre-stress beams prior to welding.
b. Record component and welding rod POs / WOs on attached material list.
c. Tag in-progress parts for straightening.

Welding on one side of the beam causes the beam to curve. Beams must be straight prior to machining slots.

a. Set beam on blocks as far apart as possible on hydraulic press.
b. Use a 2" block to distribute press loads.
c. Gradually work up to pressure required to make beam straight, usually about 800 psi is required. The same pressure generally works for beams from the same batch.
d. Check for straight with a straight edge on back of tube.
e. 78633-01 aft beams may require straightening on side as well, repeat steps a-d on side, using about 600 psi.
f. Tag in-progress parts and place on in-progress shelf in CNC shop for machining.

a. Run CNC programs to machine keyways and slots in 78633-02 tubes with guides welded in place, after straightening.
b. De-burr keyways and slots.
c. Tag in-progress parts and place on in-progress shelf in welding shop for welding.

a. Peg step: TIG weld 82735-06 cap to 82735-03 tube using jig to align cap to tube.
b. TIG weld 78633-04 bushings into 78633-02 tube using ER308L rod, four places per tube, both sides.
c. TIG weld 78633-05 stop bracket to 78633-02 tube using ER308L rod, four places per tube, both sides. Use jig to align stop brackets for height and position.
d. TIG weld 78633-06 cap to 78633-02 tube.
e. TIG weld step tube assembly from a. to back of 78633-02 tube using jig for alignment. Weld around step tube as far as possible, then close out tube by flattening protruding edge of step tube with a hammer. Complete weld after flattening.
f. Record component and welding rod POs / WOs on attached material list.
g. Tag in-progress parts and place on in-progress shelf in welding shop for straightening.

Complete
(initial or SCA #)

	#1	#2	#3	#4	#5
8. Beam Finishing	AD 73-04 10	AD 73-04 10	AD 73-04 10	AD 73-04 02	AD 73-04 02

Welding on one side of the beam causes the beam to curve. Beams must be straight prior to powder coating.

a. Set beam on blocks on hydraulic press. Straightening in sections may be required depending on severity of curve.
b. Use a 2" block to distribute press loads.
c. Gradually work up to pressure required to make beam straight, usually about 800 psi is required. The same pressure generally works for beams from the same batch.
d. Check for straight with a straight edge on back of tube.
e. 78633-01 aft beams may require straightening on side as well, repeat steps a-d on side, using about 600 psi.
f. Drill out bushings to F (0.257"), four places per beam, on drill press.
g. Break sharp edges on stops and flatten bushing locations using sanding disc on die-grinder.
h. Tag in-progress parts and place on in-progress shelf in welding shop for inspection.

9. Final Inspection	AK	AK	AK	AD 73-04 02	AK	AK

To be completed by a different person than the previous steps.

a. Inspect beams 78633-01-XX for conformity to drawings.
b. Tag in-progress parts ready for powder coating.

Local dent & pad/scrap Entered in Error

10. Powder Coating	AK Errs	N/A	AD 73-04 02 faint	AD 73-04 02	AD 73-04 02	

a. Parts are to be powder coated in accordance with commercial practices.
b. Record powder coating PO.
c. Inspect powder coating on receiving.
d. Tag in-progress parts ready for final assembly.

11. Final Assembly	AD 73-04 02	N/A	AD 73-04 10	AD 73-04 02	AD 73-04 02	

To be completed after powder coating.

a. Prepare step tube for grip tape by rubbing top surface with scotch-brite.
b. Adhere 1" 3M Safety-Walk grip tape to top surface of step tube.
c. Adhere P/N placard to back surface of beam.
d. Ensure AN4 bolt can be inserted through bushings.
e. Green tag complete beam assembly and place into stock.

Complete 16-20

MOUNTING BEAM FABRICATION – 78633

General

These instructions apply to mounting beams 78633-01 (aft) for AS350/AS355 cargo baskets. Refer to the following drawings, at the current revision, for dimensions and details:

78633 – Aft Beam

Work Order: 2017-104 RH

Batch Quantity: 36
(5 max, use additional sheets for more)

Date Open: 16 June 2017

Complete (initial or SCA #)	#1	#2	#3	#4	#5
1. Beam Fabrication – 1x2 tubes	AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02
2. CNC Machining	AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02
3. Beam Fabrication – Components	AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02

1. Beam Fabrication – 1x2 tubes
   a. Cut 1 x 2 x 0.065 material as indicated on drawings.
      i. 78633-02 – 24.44"
   b. Cut 1 x 2 x 0.120 material @ 16.38" long for upper guide (10).
   c. Record material PO on attached material list.
   d. De-burr cut ends using a sanding disc on a die-grinder. De-burr inside with de-burring tool.
   e. Remove writing on tubes with acetone.
   f. Tag in-progress parts and place on in-progress shelf in machine shop for CNC machining of keyways, slots, and bushing holes.
2. CNC Machining
   a. Run CNC programs to machine slots and holes in 78633-02 tubes.
   b. Run CNC programs to machine blanks for upper guides.
   c. De-burr slots and holes.
   d. Tag in-progress parts and place on in-progress shelf in welding shop for welding.
3. Beam Fabrication – Components
   Note: Some components are used for many different beams and are made in batches on separate component work orders. Check stock before making components.
   a. Shear caps from 0.025" sheet: 78633-06
   b. Cut 78633-03 guides from 1x1/8 stock.
   c. Cut and turn 78630-04 bushings from 3/8 x 0.065 tube.
   d. Cut 78633-04 upper guides from blanks machined in step 2.b.
   e. Cut 78633-05 stop brackets from 0.75 x 0.065 tube.
   f. Cut 82735-03 step tubes from 1.0 x 0.035 tube.
   g. Punch 82735-06 step cap from 0.050 sheet, 1.25 diameter. Flatten on steel table with a hammer.
   h. Record component POs / WOs on attached material list and place on in-progress shelf in welding shop.

Complete
(initial or SCA #)

	#1	#2	#3	#4	#5
4. Beam Welding	AD 73-04 05	AD 73-04 05	AD 73-04 05	AD 73-04 05	AD 73-04 05
5. Beam Straightening	AD 73-04 10	AD 73-04 10	AD 73-04 10	AD 73-04 10	AD 73-04 10
6. CNC Machining	AD 73-04 10	AD 73-04 10	AD 73-04 10	AD 73-04 10	AD 73-04 10
7. Beam Welding	AD 73-04 05	AD 73-04 05	AD 73-04 05	AD 73-04 05	AD 73-04 05

4. Beam Welding
   a. TIG weld 78633-03 guide, 4 places, and 78633-04 upper guide into 78633-02 tubes using ER308L rod.
      i. Clamp two beams back to back with 1/8" spacer in middle to pre-stress beams prior to welding.
   b. Record component and welding rod POs / WOs on attached material list.
   c. Tag in-progress parts for straightening.

5. Beam Straightening

   Welding on one side of the beam causes the beam to curve. Beams must be straight prior to machining slots.
   a. Set beam on blocks as far apart as possible on hydraulic press.
   b. Use a 2" block to distribute press loads.
   c. Gradually work up to pressure required to make beam straight, usually about 800 psi is required. The same pressure generally works for beams from the same batch.
   d. Check for straight with a straight edge on back of tube.
   e. 78633-01 aft beams may require straightening on side as well, repeat steps a-d on side, using about 600 psi.
   f. Tag in-progress parts and place on in-progress shelf in CNC shop for machining.

6. CNC Machining
   a. Run CNC programs to machine keyways and slots in 78633-02 tubes with guides welded in place, after straightening.
   b. De-burr keyways and slots.
   c. Tag in-progress parts and place on in-progress shelf in welding shop for welding.

7. Beam Welding
   a. Peg step: TIG weld 82735-06 cap to 82735-03 tube using jig to align cap to tube.
   b. TIG weld 78633-04 bushings into 78633-02 tube using ER308L rod, four places per tube, both sides.
   c. TIG weld 78633-05 stop bracket to 78633-02 tube using ER308L rod, four places per tube, both sides. Use jig to align stop brackets for height and position.
   d. TIG weld 78633-06 cap to 78633-02 tube.
   e. TIG weld step tube assembly from a. to back of 78633-02 tube using jig for alignment. Weld around step tube as far as possible, then close out tube by flattening protruding edge of step tube with a hammer. Complete weld after flattening.
   f. Record component and welding rod POs / WOs on attached material list.
   g. Tag in-progress parts and place on in-progress shelf in welding shop for straightening.

MOUNTING BEAM FABRICATION – 78633-01

Complete (initial or SCA #)

	#1	#2	#3	#4	#5
8. Beam Finishing	AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02

Welding on one side of the beam causes the beam to curve. Beams must be straight prior to powder coating.

a. Set beam on blocks on hydraulic press. Straightening in sections may be required depending on severity of curve.
b. Use a 2" block to distribute press loads.
c. Gradually work up to pressure required to make beam straight, usually about 800 psi is required. The same pressure generally works for beams from the same batch.
d. Check for straight with a straight edge on back of tube.
e. 78633-01 aft beams may require straightening on side as well, repeat steps a-d on side, using about 600 psi.
f. Drill out bushings to F (0.257"), four places per beam, on drill press.
g. Break sharp edges on stops and flatten bushing locations using sanding disc on die-grinder.
h. Tag in-progress parts and place on in-progress shelf in welding shop for inspection.

AD 73-04 01

9. Final Inspection	AK	AK	AK	Entered in error AD 73-04 02 AK	AD 73-04 01

To be completed by a different person than the previous steps.

a. Inspect beams 78633-01-XX for conformity to drawings.
b. Tag in-progress parts ready for powder coating.

10. Powder Coating	AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02

a. Parts are to be powder coated in accordance with commercial practices.
b. Record powder coating PO.
c. Inspect powder coating on receiving.
d. Tag in-progress parts ready for final assembly.

11. Final Assembly	AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02

To be completed after powder coating.

a. Prepare step tube for grip tape by rubbing top surface with scotch-brite.
b. Adhere 1" 3M Safety-Walk grip tape to top surface of step tube.
c. Adhere P/N placard to back surface of beam.
d. Ensure AN4 bolt can be inserted through bushings.
e. Green tag complete beam assembly and place into stock.

Complete 21-25

MOUNTING BEAM FABRICATION – 78633

General

These instructions apply to mounting beams 78633-01 (aft) for AS350/AS355 cargo baskets. Refer to the following drawings, at the current revision, for dimensions and details:

78633 – Aft Beam

Work Order: 2017-104 RH

Batch Quantity: 36
(5 max, use additional sheets for more)

Date Open: 16 June 2017

Complete (initial or SCA #)

#1	#2	#3	#4	#5
AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02

1. Beam Fabrication – 1x2 tubes
   a. Cut 1 x 2 x 0.065 material as indicated on drawings.
      i. 78633-02 – 24.44"
   b. Cut 1 x 2 x 0.120 material @ 16.38" long for upper guide (10).
   c. Record material PO on attached material list.
   d. De-burr cut ends using a sanding disc on a die-grinder. De-burr inside with de-burring tool.
   e. Remove writing on tubes with acetone.
   f. Tag in-progress parts and place on in-progress shelf in machine shop for CNC machining of keyways, slots, and bushing holes.

AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02

2. CNC Machining
   a. Run CNC programs to machine slots and holes in 78633-02 tubes.
   b. Run CNC programs to machine blanks for upper guides.
   c. De-burr slots and holes.
   d. Tag in-progress parts and place on in-progress shelf in welding shop for welding.

73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02

3. Beam Fabrication – Components
   Note: Some components are used for many different beams and are made in batches on separate component work orders. Check stock before making components.
   a. Shear caps from 0.025" sheet: 78633-06
   b. Cut 78633-03 guides from 1x1/8 stock.
   c. Cut and turn 78630-04 bushings from 3/8 x 0.065 tube.
   d. Cut 78633-04 upper guides from blanks machined in step 2.b.
   e. Cut 78633-05 stop brackets from 0.75 x 0.065 tube.
   f. Cut 82735-03 step tubes from 1.0 x 0.035 tube.
   g. Punch 82735-06 step cap from 0.050 sheet, 1.25 diameter. Flatten on steel table with a hammer.
   h. Record component POs / WOs on attached material list and place on in-progress shelf in welding shop.

Complete
(initial or SCA #)

	#1	#2	#3	#4	#5
4. Beam Welding	AD 73-04 05	AD 73-04 05	AD 73-04 05	AD 73-04 05	AD 73-04 05
5. Beam Straightening	AD 73-04 10	AD 73-04 10	AD 73-04 10	AD 73-04 10	AD 73-04 10
6. CNC Machining	AD 73-04 10	AD 73-04 10	AD 73-04 10	AD 73-04 10	AD 73-04 10
7. Beam Welding	AD 73-04 05	AD 73-04 05	AD 73-04 05	AD 73-04 05	AD 73-04 05

4. Beam Welding
   a. TIG weld 78633-03 guide, 4 places, and 78633-04 upper guide into 78633-02 tubes using ER308L rod.
      i. Clamp two beams back to back with 1/8" spacer in middle to pre-stress beams prior to welding.
   b. Record component and welding rod POs / WOs on attached material list.
   c. Tag in-progress parts for straightening.

5. Beam Straightening

   Welding on one side of the beam causes the beam to curve. Beams must be straight prior to machining slots.
   a. Set beam on blocks as far apart as possible on hydraulic press.
   b. Use a 2" block to distribute press loads.
   c. Gradually work up to pressure required to make beam straight, usually about 800 psi is required. The same pressure generally works for beams from the same batch.
   d. Check for straight with a straight edge on back of tube.
   e. 78633-01 aft beams may require straightening on side as well, repeat steps a-d on side, using about 600 psi.
   f. Tag in-progress parts and place on in-progress shelf in CNC shop for machining.

6. CNC Machining
   a. Run CNC programs to machine keyways and slots in 78633-02 tubes with guides welded in place, after straightening.
   b. De-burr keyways and slots.
   c. Tag in-progress parts and place on in-progress shelf in welding shop for welding.

7. Beam Welding
   a. Peg step: TIG weld 82735-06 cap to 82735-03 tube using jig to align cap to tube.
   b. TIG weld 78633-04 bushings into 78633-02 tube using ER308L rod, four places per tube, both sides.
   c. TIG weld 78633-05 stop bracket to 78633-02 tube using ER308L rod, four places per tube, both sides. Use jig to align stop brackets for height and position.
   d. TIG weld 78633-06 cap to 78633-02 tube.
   e. TIG weld step tube assembly from a. to back of 78633-02 tube using jig for alignment. Weld around step tube as far as possible, then close out tube by flattening protruding edge of step tube with a hammer. Complete weld after flattening.
   f. Record component and welding rod POs / WOs on attached material list.
   g. Tag in-progress parts and place on in-progress shelf in welding shop for straightening.

Complete
(initial or SCA #)

	#1	#2	#3	#4	#5
8. Beam Finishing	AL 73-02	AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02
9. Final Inspection	AD 73-04 01	AD 73-04 01	AD 73-04 01	AD 73-04 01	AD 73-04 01
10. Powder Coating	AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02
11. Final Assembly	AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02

8. Beam Finishing

Welding on one side of the beam causes the beam to curve. Beams must be straight prior to powder coating.

a. Set beam on blocks on hydraulic press. Straightening in sections may be required depending on severity of curve.
b. Use a 2" block to distribute press loads.
c. Gradually work up to pressure required to make beam straight, usually about 800 psi is required. The same pressure generally works for beams from the same batch.
d. Check for straight with a straight edge on back of tube.
e. 78633-01 aft beams may require straightening on side as well, repeat steps a-d on side, using about 600 psi.
f. Drill out bushings to F (0.257"), four places per beam, on drill press.
g. Break sharp edges on stops and flatten bushing locations using sanding disc on die-grinder.
h. Tag in-progress parts and place on in-progress shelf in welding shop for inspection.

9. Final Inspection

To be completed by a different person than the previous steps.

a. Inspect beams 78633-01-XX for conformity to drawings.
b. Tag in-progress parts ready for powder coating.

10. Powder Coating

a. Parts are to be powder coated in accordance with commercial practices.
b. Record powder coating PO.
c. Inspect powder coating on receiving.
d. Tag in-progress parts ready for final assembly.

11. Final Assembly

To be completed after powder coating.

a. Prepare step tube for grip tape by rubbing top surface with scotch-brite.
b. Adhere 1" 3M Safety-Walk grip tape to top surface of step tube.
c. Adhere P/N placard to back surface of beam.
d. Ensure AN4 bolt can be inserted through bushings.
e. Green tag complete beam assembly and place into stock.

26-30 complete.

MOUNTING BEAM FABRICATION – 78633

General

These instructions apply to mounting beams 78633-01 (aft) for AS350/AS355 cargo baskets. Refer to the following drawings, at the current revision, for dimensions and details:

78633 – Aft Beam

Work Order: 2017-104 RH

Batch Quantity: 36
(5 max, use additional sheets for more)

Complete
(initial or SCA #)

Date Open: 16 June 2017

#1	#2	#3	#4	#5
AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02

1. Beam Fabrication – 1x2 tubes
   a. Cut 1 x 2 x 0.065 material as indicated on drawings.
      i. 78633-02 – 24.44"
   b. Cut 1 x 2 x 0.120 material @ 16.38" long for upper guide (10).
   c. Record material PO on attached material list.
   d. De-burr cut ends using a sanding disc on a die-grinder. De-burr inside with de-burring tool.
   e. Remove writing on tubes with acetone.
   f. Tag in-progress parts and place on in-progress shelf in machine shop for CNC machining of keyways, slots, and bushing holes.

AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02

2. CNC Machining
   a. Run CNC programs to machine slots and holes in 78633-02 tubes.
   b. Run CNC programs to machine blanks for upper guides.
   c. De-burr slots and holes.
   d. Tag in-progress parts and place on in-progress shelf in welding shop for welding.

AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02

3. Beam Fabrication – Components
   Note: Some components are used for many different beams and are made in batches on separate component work orders. Check stock before making components.
   a. Shear caps from 0.025" sheet: 78633-06
   b. Cut 78633-03 guides from 1x1/8 stock.
   c. Cut and turn 78630-04 bushings from 3/8 x 0.065 tube.
   d. Cut 78633-04 upper guides from blanks machined in step 2.b.
   e. Cut 78633-05 stop brackets from 0.75 x 0.065 tube.
   f. Cut 82735-03 step tubes from 1.0 x 0.035 tube.
   g. Punch 82735-06 step cap from 0.050 sheet, 1.25 diameter. Flatten on steel table with a hammer.
   h. Record component POs / WOs on attached material list and place on in-progress shelf in welding shop.

Complete
(initial or SCA #)

	#1	#2	#3	#4	#5
4. Beam Welding	AD 73-04 05	AD 73-04 05	AD 73-04 05	AD 73-04 05	AD 73-04 05
5. Beam Straightening	AD 73-04 10	AD 73-04 10	AD 73-04 10	AD 73-04 10	AD 73-04 10
6. CNC Machining	AD 73-04 10	AD 73-04 10	AD 73-04 10	AD 73-04 10	AD 73-04 10
7. Beam Welding	AD 73-04 05	AD 73-04 05	AD 73-04 05	AD 73-04 05	AD 73-04 05

4. Beam Welding
   a. TIG weld 78633-03 guide, 4 places, and 78633-04 upper guide into 78633-02 tubes using ER308L rod.
      i. Clamp two beams back to back with 1/8" spacer in middle to pre-stress beams prior to welding.
   b. Record component and welding rod POs / WOs on attached material list.
   c. Tag in-progress parts for straightening.

5. Beam Straightening

   Welding on one side of the beam causes the beam to curve. Beams must be straight prior to machining slots.
   a. Set beam on blocks as far apart as possible on hydraulic press.
   b. Use a 2" block to distribute press loads.
   c. Gradually work up to pressure required to make beam straight, usually about 800 psi is required. The same pressure generally works for beams from the same batch.
   d. Check for straight with a straight edge on back of tube.
   e. 78633-01 aft beams may require straightening on side as well, repeat steps a-d on side, using about 600 psi.
   f. Tag in-progress parts and place on in-progress shelf in CNC shop for machining.

6. CNC Machining
   a. Run CNC programs to machine keyways and slots in 78633-02 tubes with guides welded in place, after straightening.
   b. De-burr keyways and slots.
   c. Tag in-progress parts and place on in-progress shelf in welding shop for welding.

7. Beam Welding
   a. Peg step: TIG weld 82735-06 cap to 82735-03 tube using jig to align cap to tube.
   b. TIG weld 78633-04 bushings into 78633-02 tube using ER308L rod, four places per tube, both sides.
   c. TIG weld 78633-05 stop bracket to 78633-02 tube using ER308L rod, four places per tube, both sides. Use jig to align stop brackets for height and position.
   d. TIG weld 78633-06 cap to 78633-02 tube.
   e. TIG weld step tube assembly from a. to back of 78633-02 tube using jig for alignment. Weld around step tube as far as possible, then close out tube by flattening protruding edge of step tube with a hammer. Complete weld after flattening.
   f. Record component and welding rod POs / WOs on attached material list.
   g. Tag in-progress parts and place on in-progress shelf in welding shop for straightening.

Complete
(initial or SCA #)

	#1	#2	#3	#4	#5
8. Beam Finishing	AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02

Welding on one side of the beam causes the beam to curve. Beams must be straight prior to powder coating.

a. Set beam on blocks on hydraulic press. Straightening in sections may be required depending on severity of curve.
b. Use a 2" block to distribute press loads.
c. Gradually work up to pressure required to make beam straight, usually about 800 psi is required. The same pressure generally works for beams from the same batch.
d. Check for straight with a straight edge on back of tube.
e. 78633-01 aft beams may require straightening on side as well, repeat steps a-d on side, using about 600 psi.
f. Drill out bushings to F (0.257"), four places per beam, on drill press.
g. Break sharp edges on stops and flatten bushing locations using sanding disc on die-grinder.
h. Tag in-progress parts and place on in-progress shelf in welding shop for inspection.

9. Final Inspection	AD 73-04 01	AD 73-04 01	AD 73-04 01	AD 73-04 01	AD 73-04 01

To be completed by a different person than the previous steps.

a. Inspect beams 78633-01-XX for conformity to drawings.
b. Tag in-progress parts ready for powder coating.

10. Powder Coating	AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02

a. Parts are to be powder coated in accordance with commercial practices.
b. Record powder coating PO.
c. Inspect powder coating on receiving.
d. Tag in-progress parts ready for final assembly.

11. Final Assembly	AD 73-04 02	AD 73-04 02 ENTERED IN ERROR	AD 73-04 02	AD 73-04 02	AD 73-04 02

To be completed after powder coating.

a. Prepare step tube for grip tape by rubbing top surface with scotch-brite.
b. Adhere 1" 3M Safety-Walk grip tape to top surface of step tube.
c. Adhere P/N placard to back surface of beam.
d. Ensure AN4 bolt can be inserted through bushings.
e. Green tag complete beam assembly and place into stock.

Aero Design Ltd.
9888 A Malaspina Rd. Powell River, BC, V8A 0G3
Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: UPPER GUIDE (ASSY RH) No. of pieces: 10
Manufacturer: AERO DESIGN LTD
Part No.: 7AG33-04-01 Serial/Batch No.: CQ 17050
TTSN: N/A TSO: N/A Rem.: N/A
Work Order No.: 2017-124
Remaining Tasks to be Performed: CUT APART, DE BURR

Signature:
Date: 11 AUG 2017 Lic. No. / SCA A002

In Process

Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

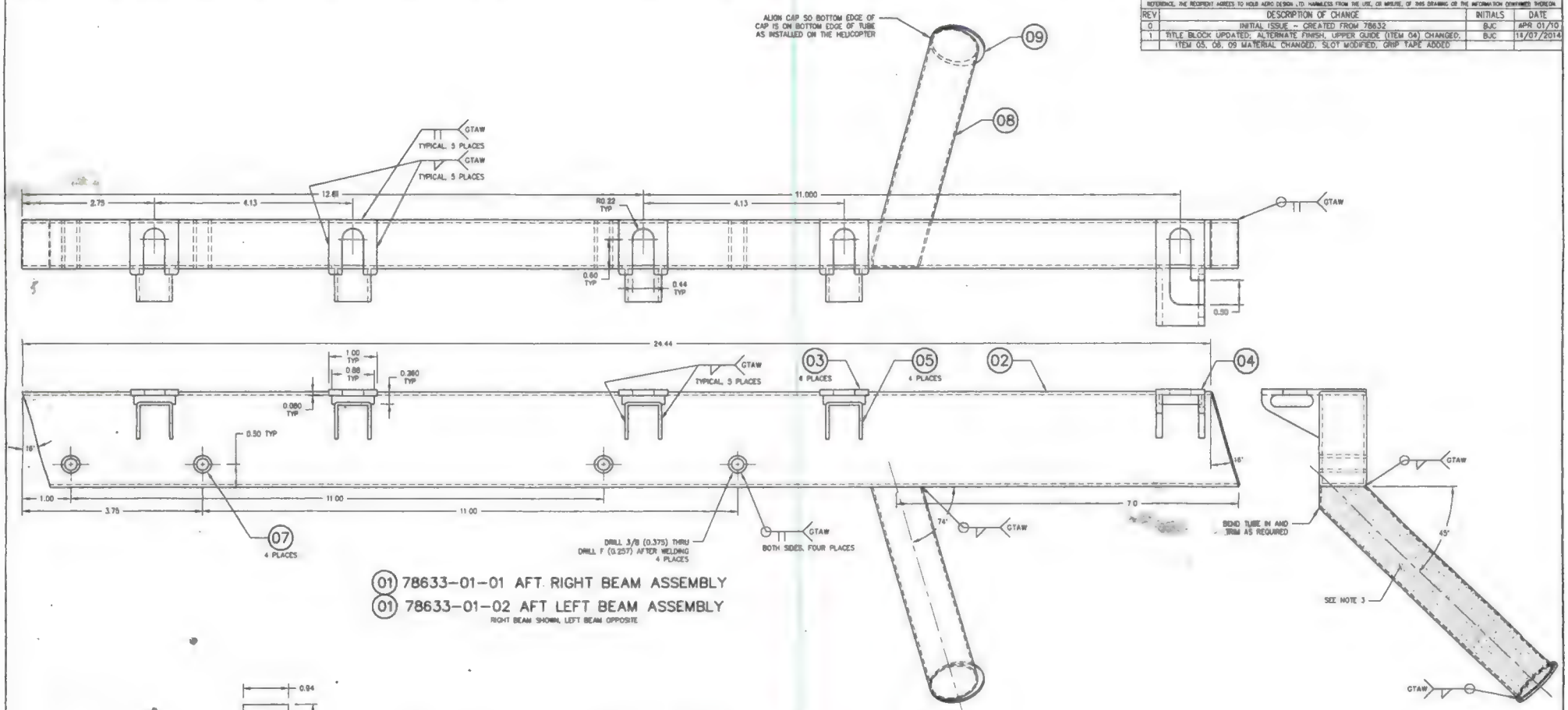
AMF 73-04

Remarks

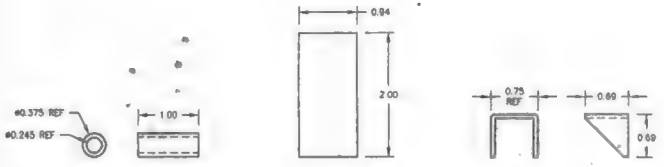
In Process

2017-104 RH x36

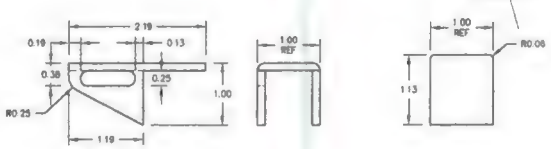
REV	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE – CREATED FROM 78632	BJC	APR 01/10
1	TITLE BLOCK UPDATED; ALTERNATE FINISH, UPPER GUIDE (ITEM 04) CHANGED; ITEM 05, 08, 09 MATERIAL CHANGED, SLOT MODIFIED, GRIP TAPE ADDED	BJC	18/07/2014



(01) 78633-01-01 AFT RIGHT BEAM ASSEMBLY
(01) 78633-01-02 AFT LEFT BEAM ASSEMBLY
RIGHT BEAM SHOWN, LEFT BEAM OPPOSITE



(07) BUSHING (06) CAP (05) STOP BRACKET



(04) UPPER GUIDE
RIGHT PART SHOWN, LEFT PART OPPOSITE

(03) GUIDE

NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
2. WELDING OF 304 STAINLESS STEEL TO BE COMPLETED BY GTAW METHOD TO AMS2685C WELDING ROD SHALL CONFORM TO ER308L OR EQUIVALENT
3. FINISH: ALL STEEL PARTS TO BE THOROUGHLY DEGREASED AND POWDER COATED PRIOR TO ASSEMBLY ALTERNATE: ALL STEEL PARTS TO BE THOROUGHLY DEGREASED, PRIMED AND PAINTED PRIOR TO ASSEMBLY APPLY GRIP TAPE TO TOP SURFACE OF STEP AFTER FINISHING.

(08) TUBE (09) CAP

QTY -02	QTY -01	PART NO	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
1	1	78633-10	10	GRIP TAPE	3M SAFETY WALK	COMMERCIAL	1" WIDE
1	1	78633-09	09	CAP	304 STAINLESS STEEL	AMS 5513	0.050 SHEET
1	1	78633-08	08	TUBE	316 STAINLESS STEEL	ASTM A269	1.0 X 0.065 TUBE
4	4	78630-04	07	BUSHING	304 STAINLESS STEEL	ASTM A269	ø0.375 X 0.065 RND TUBE
1	1	78633-06	06	CAP	304 STAINLESS STEEL	AMS 5513	0.050 SHEET
4	4	78633-05	05	STOP BRACKET	304 STAINLESS STEEL	ASTM A554	0.75 X 0.035 SQR TUBE
1	1	78633-04	04	UPPER GUIDE	304 STAINLESS STEEL	ASTM A554	1 X 2 X 0.125 TUBE
4	4	78633-03	03	GUIDE	304 STAINLESS STEEL	ASTM A240	1.0 X 0.125 BAR
1	1	78633-02	02	TUBE	304 STAINLESS STEEL	ASTM A554	1 X 2 X 0.065 TUBE
	1	78633-01-02	01	AFT LEFT BEAM ASS'Y			
1		78633-01-01	01	AFT RIGHT BEAM ASS'Y			

LIST OF MATERIALS

APPROVALS		DATE
DRAWN:	JEFF CLARKE	01 APR 2010
CHECKED:	E BURGOIN	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES ON:
DECIMALS: X.XXX ±0.010; X.XX ±0.03; X.X ±0.1
ANGLES: ±1/2°

AERO DESIGN LTD.
9808A MALASPINA ROAD
POWELL RIVER, BC, CANADA, V8A 0G3
TEL 604.485.2576 www.aerodesign.ca

EUROCOPTER AS350 & AS355 SERIES
ATTACHMENT PROVISIONS
AFT BEAM FABRICATION

SCALE 1 : 1	DWG SIZE	DWG NO	REV
SHEET 1 OF 1	A1	78633	1

Work Order: 2017-104

Date Opened: 16 JUNE 2017

Material Tracking Sheet
Eurocopter AS350/AS355 Aft Mounting Beam

RH

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	36		78633-01-01	**Aft Beam Assembly**	(XX = ~~-01 RH,~~ -02 LH)	
Step 1				*Fabrication*		
	.1		78633-02	Tube	1x2x0.065 Tube, 304 Stainless Steel	17050
	.1		78633-04	Upper Guide	1x2x0.12 Tube, 304 Stainless Steel	2017-79 (35) 17050 (10)
Step 2				*Machning*	*None*	
Step 3				*Fabrication*		
	.4		78633-03	Guide	1x0.125 Bar, 304 Stainless Steel	16085
	.4		78633-05	Stop Bracket	0.75x0.065 Sqr. Tube, 304 Stainless	17058
	.1		78633-06	Cap	0.050" Sheet, 304 Stainless Steel	2017-104
	.4		78630-04	Bushing	0.375 x 0.065 Tube, 304 Stainless Steel	17050
	.1		82735-03	Tube	1.0 x ~~0.035~~ Tube, 316 Stainless Steel	17005
	.1		82735-06	Cap	0.050 Sheet, 304 Stainless Steel	10037
Step 5				*Welding*		
	.A/R			Welding Rod	ER308L	17066
Step 7				*Straightening*	*None*	
Step 8				*Machning*	*None*	
Step 9				*Welding*		
	.A/R			Welding Rod	ER308L	17066
Step 11				*Finishing*	*None*	
Step 12				*Final Inspection*	*None*	
Step 13				*Powder Coating*	15019 2 Blk/12 WHT 15082 1 BLUE	17074 17088 17105 (1) (6) (5) Red 17117 (4) Blk
		Detail				

Work Order:_____

Material Tracking Sheet
Eurocopter AS350/AS355 Aft Mounting Beam

Date Opened:_____

Ass'y Step	Qty	Drawing	Part Number	Description	Material	PO/WO
Step 14				*Final Assembly*		
	. 1		--	Grip Tape	1" 3M Safety Walk	
	. 1		--	P/N Placard	TZ tape, 1/2", white on black	

1. Approving Civil Aviation Authority/Country	2. AUTHORIZED RELEASE CERTIFICATE FORM ONE	3.Form Tracking No.
Transport Canada		2019-0066
4. Organization Name and Address		5. Work Order/Contract/Invoice
AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3		PO LR684

6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
1.	Aft RH Beam	78633-01-01	2	WO 2017-104	New

12. Remarks

Certification data: TCCA STC SH08-16

13a. Certifies that the items identified above were manufactured in conformity to:	14a. ☐ CAR 571.10 Maintenance Release ☐ Other regulation specified in block 12
☒ Approved design data and are in condition for safe operation. ☐ Non approved design data specified in block 12.	Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the *Canadian Aviation Regulations*.

13b. Signature	13c. Approved Organization Number	14b. Signature	14c. Approved Organization Number
AD 73-04 02	AMF 73-04		
13d. Name	**13e. Date (dd/mmm/yyyy)**	**14d. Name**	**14e. Date (dd/mmm/yyyy)**
Jeff Clarke - AD02	19 Mar 2019		

Installer Responsibilities

This certificate does not constitute authority to install.

Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.

Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.

LR HELICOPTERS

Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

In Process

Remarks

POWDER PO 15019

Aero Design Ltd.
9888 A Malaspina Rd. Powell River, BC, V8A 0G3
Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: AS350 AFT RH Beam No. of pieces: 1

Manufacturer: Aero Design

Part No.: 78633-01-01 Serial/Batch No.: NSN

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2017-104

Remaining Tasks to be Performed: Clean up ✓, Straighten ✓ + Powder ✓

AO 73-04 05

Signature: David Beatty

Date: 17/12/12 Lic. No. / SCA

In Process

LA HELICOPTERS
19 MAR 2019

Aero Design

Parts Distribution Sheet

Description: AS350 RH Beams

WO# 2017-104

From PO or WO #	Quantity	Description	Part Number	For WO #
2017-104	1	RH Aft Beam	78633-01-01	
17061	1	Grip Tape	3M Safety Walk	

Aero Design Ltd.
9888 A Malaspina Rd. Powell River, BC, V8A 0G3
Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

In Process

Remarks

powder fo F019

Aero Design Ltd.
9888 A Malaspina Rd. Powell River, BC, V8A 0G3
Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: AS350 AFT RH Beam No. of pieces: 1

Manufacturer: Aero Design

Part No.: 78633-01-01 Serial/Batch No.: NSN

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2017-104

Remaining Tasks to be Performed: clean up ✓, Straighten ✓ + Powder ✓

Signature: [signature] AD 73-04

Date: 17/12/12 Lic. No. / SCA 05

In Process

LR HELICOPTERS
16 MAR 2019

Aero Design

Parts Distribution Sheet

Description: AS350 RH Beams

WO# 2017-104

From PO or WO #	Quantity	Description	Part Number	For WO #
2017-104	1	RH Aft Beam	78633-01-01	
17061	1	Grip Tape	3M Safety Walk	

1. Approving Civil Aviation Authority/Country	2. AUTHORIZED RELEASE CERTIFICATE FORM ONE	3.Form Tracking No.
Transport Canada		2019-0034

4. Organization Name and Address	5. Work Order/Contract/Invoice
AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3	PO_169

6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
1.	Aft RH Beam	78633-01-01	1	WO 2017-104	New

12. Remarks

Certification data: TCCA STC SH08-16

Black

13a. Certifies that the items identified above were manufactured in conformity to:

☒ Approved design data and are in condition for safe operation.

☐ Non approved design data specified in block 12.

~~14a.~~ ☐ CAR 571.10 Maintenance Release

☐ Other regulation specified in block 12

Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the *Canadian Aviation Regulations*.

13b. Signature	13c. Approved Organization Number	~~14b. Signature~~	~~14c. Approved Organization Number~~
AD 73-04 02	AMF 73-04		
13d. Name	**13e. Date (dd/mmm/yyyy)**	**~~14d. Name~~**	**~~14e. Date (dd/mmm/yyyy)~~**
Jeff Clarke - AD02	19 Feb 2019		

Installer Responsibilities

This certificate does not constitute authority to install.

Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.

Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.

GLACIER HELICOPTERS

Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

In Process

Remarks

Powder fo 18019

Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: AS350 AFT ± RH Bay No. of pieces: 1

Manufacturer: Aero Design

Part No.: 78633-01-01 Serial/Batch No.: NSN

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2017-104

Remaining Tasks to be Performed: Clean up ✓, straighten ✓ Powdure Powder ✓

Signature: David Swartz

Date: 17/12/12 Lic. No. / SCA ~~AD~~ 73-04 05

In Process

GLACIER HELICOPTERS

19 FEB 2019

Aero Design

Parts Distribution Sheet

Description: AS350 RH Beams

WO# 2017-104

From PO or WO #	Quantity	Description	Part Number	For WO #
2017-104	1	RH Aft Beam	78633-01-01	
17061	1	Grip Tape	3M Safety Walk	

1. Approving Civil Aviation Authority/Country	2. AUTHORIZED RELEASE CERTIFICATE FORM ONE				3.Form Tracking No.
Transport Canada					2019-0095
4. Organization Name and Address					5. Work Order/Contract/Invoice
AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					PO 001AeroDesign
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
1.	Aft RH Beam	78633-01-01	1	WO 2017-104	New
12. Remarks					
Certification data: TCCA STC SH08-16; FAA STC SR02680NY; EASA STC 10060494					

13a. Certifies that the items identified above were manufactured in conformity to:	14a. ☐ CAR 571.10 Maintenance Release
☒ Approved design data and are in condition for safe operation.	☐ Other regulation specified in block 12
☐ Non approved design data specified in block 12.	Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the *Canadian Aviation Regulations*.

13b. Signature	13c. Approved Organization Number	14b. Signature	14c. Approved Organization Number
AD 73-04 02	AMF 73-04		
13d. Name	**13e. Date (dd/mmm/yyyy)**	**14d. Name**	**14e. Date (dd/mmm/yyyy)**
Jeff Clarke - AD02	16 Apr 2019		

Installer Responsibilities

This certificate does not constitute authority to install.

Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.

Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.

WIB

Aero Design Ltd.
9888 A Malaspina Rd. Powell River, BC, V8A 0G3
Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

In Process

Remarks

POWDER PO 18019

Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: AS350 AFT RH Beam No. of pieces: 1

Manufacturer: Aero Design

Part No.: 78633-01-01 Serial/Batch No.: NSN

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2017-104

Remaining Tasks to be Performed: Clean up & Straighten + Powder ✓ ✓

Signature: [signature] AD 73-04

Date: 17/12/12 Lic. No. / SCA 05

In Process

WLB

16 APR 2019

Aero Design

Parts Distribution Sheet

Description: AS350 RH Beams WO#

From PO or WO #	Quantity	Description	Part Number	For WO #
2017-104	1	RH Aft Beam	78633-01-01	
17061	1	Grip Tape	3M Safety Walk	

WB
16 Apr 2019

Aero Design

Parts Distribution Sheet

Description: AS350 Beams Hardware WO# _____

From PO or WO #	Quantity	Description	Part Number	For WO #
17070	4	Bolt	AN4-14A	
17070	4	Bolt	AN4-15A	
17070	4	Washer	NAS1149F0463P	
18031	12	Washer	Commercial	

WB
16 APR 2019

Aero Design

Parts Distribution Sheet

Description: AS350 Beams Hardware WO#

From PO or WO #	Quantity	Description	Part Number	For WO #
17070	4	Bolt	AN4-14A	
17070	4	Bolt	AN4-15A	
17070	4	Washer	NAS1149F0463P	
18031	12	Washer	Commercial	

1. Approving Civil Aviation Authority/Country	2. AUTHORIZED RELEASE CERTIFICATE FORM ONE	3.Form Tracking No.
Transport Canada		2019-0078

4. Organization Name and Address	5. Work Order/Contract/Invoice
AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3	PO ISA1

6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
1.	Aft RH Beam	78633-01-01	1	WO 2017-104	New

12. Remarks

Certification data: TCCA STC SH08-16; FAA STC SR02680NY

Black

13a. Certifies that the items identified above were manufactured in conformity to:

☒ Approved design data and are in condition for safe operation.

☐ Non approved design data specified in block 12.

14a. ☐ CAR 571.10 Maintenance Release

☐ Other regulation specified in block 12

Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the *Canadian Aviation Regulations*.

13b. Signature	13c. Approved Organization Number	14b. Signature	14c. Approved Organization Number
AD 73-04 02	AMF 73-04		
13d. Name	**13e. Date (dd/mmm/yyyy)**	**14d. Name**	**14e. Date (dd/mmm/yyyy)**
Jeff Clarke - AD02	01 Apr 2019		

Installer Responsibilities

This certificate does not constitute authority to install.

Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.

Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.

ICY STRAIGHT AVIATION

Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

In Process

Remarks

POWDER TO 15019

Aero Design Ltd.
9888 A Malaspina Rd. Powell River, BC, V8A 0G3
Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: AS350 AFT RH Beam No. of pieces: 1

Manufacturer: Aero Design

Part No.: 78633-01-01 Serial/Batch No.: NSN

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2017-104

Remaining Tasks to be Performed: clean up ✓, straighten ✓ + Powder ✓

AD 73-04 05

Signature: David Mantz

Date: 17/12/12 Lic. No. / SCA

In Process

ICY STRAIGHT
01 APR 2019

Aero Design
Parts Distribution Sheet

Description: AS350 RH Beams

WO# 2017-104

From PO or WO #	Quantity	Description	Part Number	For WO #
2017-104	1	RH Aft Beam	78633-01-01	
17061	1	Grip Tape	3M Safety Walk	

1. Approving Civil Aviation Authority/Country	2. AUTHORIZED RELEASE CERTIFICATE FORM ONE	3.Form Tracking No.
Transport Canada		2019-0010

4. Organization Name and Address	5. Work Order/Contract/Invoice
AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3	PO 190101

6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
1.	Aft RH Beam	78633-01-01	2	WO 2017-104	New

12. Remarks

Certification data: TCCA STC SH08-16

13a. Certifies that the items identified above were manufactured in conformity to:	14a. ☐ CAR 571.10 Maintenance Release ☐ Other regulation specified in block 12
☒ Approved design data and are in condition for safe operation. ☐ Non approved design data specified in block 12.	Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the *Canadian Aviation Regulations*.
13b. Signature PC 73-04 02	13c. Approved Organization Number AMF 73-04
13d. Name Jeff Clarke - AD02	13e. Date (dd/mmm/yyyy) 03 Jan 2019

14b. Signature	14c. Approved Organization Number
14d. Name	14e. Date (dd/mmm/yyyy)

Installer Responsibilities

This certificate does not constitute authority to install.

Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.

Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.

WEST COAST HELI

Aero Design Ltd.
9888 A Malaspina Rd. Powell River, BC, V8A 0G3
Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

In Process

Remarks

POWDER PO 18019

Aero Design Ltd.
9888 A Malaspina Rd. Powell River, BC, V8A 0G3
Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: AS350 AFT RH Beam No. of pieces: 1

Manufacturer: Aero Design

Part No.: AD633-01-01 Serial/Batch No.: NSN

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2017-104

Remaining Tasks to be Performed: Clean up ✓, Straighten ✓ + Powder ✓

Signature: [signature]

Date: 17/12/12 Lic. No. / SCA NO 73-04 05

In Process

WEST COAST HELI
03 JAN 2019

Aero Design

Parts Distribution Sheet

Description: AS350 RH Beams

WO# 2017-104

From PO or WO #	Quantity	Description	Part Number	For WO #
2017-104	1	RH Aft Beam	78633-01-01	
16051	1	Grip Tape	3M Safety Walk	

Aero Design Ltd.
9888 A Malaspina Rd. Powell River, BC, V8A 0G3
Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: AS350 AFT RH Beam No. of pieces: 1
Manufacturer: Aero Design
Part No.: ~~X~~ 78633 -01-01 Serial/Batch No.: NSN
TTSN: N/A TSO: N/A Rem.: N/A
Work Order No.: 2017 - 104
Remaining Tasks to be Performed: Clean up ✓, Straighten ✓ + Powder ✓

Signature: David Beatty
Date: 17/12/12 Lic. No. / SCA ~~AD~~ 73-04 05

In Process

Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Remarks

In Process

WEST COAST HELI
03 JAN ~~2018~~ 2019 JC

Aero Design

Parts Distribution Sheet

Description: AS350 RH Beams

WO# 2017-104

From PO or WO #	Quantity	Description	Part Number	For WO #
2017-104	1	RH Aft Beam	78633-01-01	
16051	1	Grip Tape	3M Safety Walk	

1. Approving Civil Aviation Authority/Country	2. AUTHORIZED RELEASE CERTIFICATE FORM ONE	3.Form Tracking No.
Transport Canada		2018-0297

4. Organization Name and Address	5. Work Order/Contract/Invoice
AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3	Inv. 997

6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
1.	Aft RH Beam	78633-01-01	1	WO 2017-104	New

12. Remarks

Certification data: TCCA STC SH08-16; FAA STC SR02680NY

13a. Certifies that the items identified above were manufactured in conformity to:

☒ Approved design data and are in condition for safe operation.

☐ Non approved design data specified in block 12.

14a. ☐ CAR 571.10 Maintenance Release

☐ Other regulation specified in block 12

Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the *Canadian Aviation Regulations*.

13b. Signature	13c. Approved Organization Number	14b. Signature	14c. Approved Organization Number
AD 73-04 02	AMF 73-04		
13d. Name	**13e. Date (dd/mmm/yyyy)**	**14d. Name**	**14e. Date (dd/mmm/yyyy)**
Jeff Clarke - AD02	11 Dec 2018		

Installer Responsibilities

This certificate does not constitute authority to install.

Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.

Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.

OVER THE TOP

Aero Design Ltd.
9888 A Malaspina Rd. Powell River, BC, V8A 0G3
Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: AS350 AFT RH Beam No. of pieces: 1

Manufacturer: Aero Design

Part No.: 78633 -01 -01 Serial/Batch No.: NSN

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2017 - 104

Remaining Tasks to be Performed: Clean up ✓, Straighten ✓ + Powder ✓

Signature: [signature]

Date: 17/12/12 Lic. No. / SCA AD 73-04 05

In Process

Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

In Process

Remarks

POWDER P118019

OVER THE TOP
11 DEC 2018

Aero Design

Parts Distribution Sheet

Description: AS350 RH Beams

WO# 2017-104

From PO or WO #	Quantity	Description	Part Number	For WO #
2017-104	1	RH Aft Beam	78633-01-01	
16051	1	Grip Tape	3M Safety Walk	

1. Approving Civil Aviation Authority/Country	2. AUTHORIZED RELEASE CERTIFICATE FORM ONE	3.Form Tracking No.
Transport Canada		2018-0280

4. Organization Name and Address	5. Work Order/Contract/Invoice
AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3	PO 33669

6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
1.	Aft RH Beam	78633-01-01	1	WO 2017-104	New

12. Remarks

Certification data: TCCA STC SH08-16

13a. Certifies that the items identified above were manufactured in conformity to:

☒ Approved design data and are in condition for safe operation.

☐ Non approved design data specified in block 12.

~~14a.~~ ☐ CAR 571.10 Maintenance Release

☐ Other regulation specified in block 12

Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the *Canadian Aviation Regulations*.

13b. Signature	13c. Approved Organization Number	~~14b. Signature~~	~~14c. Approved Organization Number~~
AD 73-04 02	AMF 73-04		
13d. Name	**13e. Date (dd/mmm/yyyy)**	**~~14d. Name~~**	**~~14e. Date (dd/mmm/yyyy)~~**
Jeff Clarke - AD02	23 Nov 2018		

Installer Responsibilities

This certificate does not constitute authority to install.

Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.

Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.

BLACK TUSK

Aero Design Ltd.
9888 A Malaspina Rd. Powell River, BC, V8A 0G3
Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

In Process

Remarks

Step: 8. ✓
9. ✓
10. ✓ 17088
11. ✓

Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: Aft. Beam R/H No. of pieces: 1

Manufacturer: Aero Design Ltd.

Part No.: 76633-01-01 Serial/Batch No.: NA

TTSN: NA TSO: NA Rem.: NA

Work Order No.: 2017-104

Remaining Tasks to be Performed: See reverse.

Signature: David Smith AD 73-04

Date: Sept. 13/2017 Lic. No. / SCA 05

Form# 20.E.03 Rev. 1 24 April 2014

In Process

BLACK TUSK
22 NOV 2018

Aero Design

Parts Distribution Sheet

Description: AS350 RH Beams

WO# 2018-76

From PO or WO #	Quantity	Description	Part Number	For WO #
2017-104	1	RH Aft Beam	78633-01-01	
16051	1	Grip Tape	3M Safety Walk	

Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

In Process

Remarks

POWDER PO 15019 RE CONT 1 of 2

Aero Design Ltd.
9888 A Malaspina Rd. Powell River, BC, V8A 0G3
Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: AS350 AFT RH Beam No. of pieces: 1

Manufacturer: Aero Design

Part No.: 78633-01-81 Serial/Batch No.: NSN

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2017-104

Remaining Tasks to be Performed: Clean up ✓, Straighten ✓ + Powder ✓

Signature: [signature]

Date: 17/12/12 Lic. No. / SCA AD 73-04 05

In Process

WEST CIRQUE
31 OCT 2018

Aero Design

Parts Distribution Sheet

Description: AS350 RH Beams

WO# 2017-104

From PO or WO #	Quantity	Description	Part Number	For WO #
2017-104	1	RH Aft Beam	78633-01-01	
16051	1	Grip Tape	3M Safety Walk	

1. Approving Civil Aviation Authority/Country	2. AUTHORIZED RELEASE CERTIFICATE FORM ONE	3.Form Tracking No.
Transport Canada		2018-0261

4. Organization Name and Address	5. Work Order/Contract/Invoice
AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3	None

6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
1.	Aft RH Beam	78633-01-01	1	WO 2017-104	New

12. Remarks

Certification data: TCCA STC SH08-16

Blue

13a. Certifies that the items identified above were manufactured in conformity to:

☒ Approved design data and are in condition for safe operation.

☐ Non approved design data specified in block 12.

~~14a.~~ ☐ CAR 571.10 Maintenance Release

☐ Other regulation specified in block 12

Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the *Canadian Aviation Regulations*.

13b. Signature	13c. Approved Organization Number	~~14b. Signature~~	~~14c. Approved Organization Number~~
AD 73-04 02	AMF 73-04		
13d. Name	**13e. Date (dd/mmm/yyyy)**	**~~14d. Name~~**	**~~14e. Date (dd/mmm/yyyy)~~**
Jeff Clarke - AD02	31 Oct 2018		

Installer Responsibilities

This certificate does not constitute authority to install.

Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.

Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.

WEST CIRQUE

1. Approving Civil Aviation Authority/Country	2. AUTHORIZED RELEASE CERTIFICATE FORM ONE	3.Form Tracking No.
Transport Canada		2018-0245
4. Organization Name and Address		5. Work Order/Contract/Invoice
AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3		PO 3060

6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
1.	Aft RH Beam	78633-01-01	1	WO 2017-104	New

12. Remarks

Certification data: TCCA STC SH08-16

Black

Revised 07 Nov 2018 - Colour updated to black JC.

13a. Certifies that the items identified above were manufactured in conformity to:	14a. ☐ CAR 571.10 Maintenance Release ☐ Other regulation specified in block 12
☒ Approved design data and are in condition for safe operation. ☐ Non approved design data specified in block 12.	Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the *Canadian Aviation Regulations*.

13b. Signature	13c. Approved Organization Number	14b. Signature	14c. Approved Organization Number
AD 73-04 02	AMF 73-04		
13d. Name	**13e. Date (dd/mmm/yyyy)**	**14d. Name**	**14e. Date (dd/mmm/yyyy)**
Jeff Clarke - AD02	05 Oct 2018		

Installer Responsibilities

This certificate does not constitute authority to install.

Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.

Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.

SELKIRK MOUNTAIN HELI

1. Approving Civil Aviation Authority/Country	2. AUTHORIZED RELEASE CERTIFICATE FORM ONE	3.Form Tracking No.
Transport Canada		2018-0245

4. Organization Name and Address	5. Work Order/Contract/Invoice
AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3	PO 3060

6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
1.	Aft RH Beam	78633-01-01	1	WO 2017-104	New

12. Remarks

Certification data: TCCA STC SH08-16

13a. Certifies that the items identified above were manufactured in conformity to:

☒ Approved design data and are in condition for safe operation.

☐ Non approved design data specified in block 12.

14a. ☐ CAR 571.10 Maintenance Release

☐ Other regulation specified in block 12

Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the *Canadian Aviation Regulations*.

13b. Signature	13c. Approved Organization Number	14b. Signature	14c. Approved Organization Number
AD 73-04 02	AMF 73-04		
13d. Name	**13e. Date (dd/mmm/yyyy)**	**14d. Name**	**14e. Date (dd/mmm/yyyy)**
Jeff Clarke - AD02	05 Oct 2018		

Installer Responsibilities

This certificate does not constitute authority to install.

Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.

Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.

SELKIRK MOUNTAIN HELI

Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

In Process

Remarks

Powder PO 18019

Aero Design Ltd.
9888 A Malaspina Rd. Powell River, BC, V8A 0G3
Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: AS350 AFT RH Beam No. of pieces: 1

Manufacturer: Aero Design

Part No.: 28 78633-01-01 Serial/Batch No.: NSN

TTSN: N/A TSO: N/F Rem.: N/A

Work Order No.: 207-104

Remaining Tasks to be Performed: clean up ✓, Straighten ✓ Powder ✓

Signature: David Beatty

Date: 17/12/12 Lic. No. / SCA AD 73-04 05

In Process

Selkirk Mountain Helicopters Ltd.

Aero Design

Parts Distribution Sheet

Description: AS350 RH Beams

WO# 2017-102

From PO or WO #	Quantity	Description	Part Number	For WO #
2017-104	1	RH Aft Beam	78633-01-01	
17061	1	Grip Tape	3M Safety Walk	

1. Approving Civil Aviation Authority/Country	2. AUTHORIZED RELEASE CERTIFICATE FORM ONE	3.Form Tracking No.
Transport Canada		2018-0242
4. Organization Name and Address		5. Work Order/Contract/Invoice
AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3		None

6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
1.	Aft RH Beam	78633-01-01	1	WO 2017-104	New

12. Remarks

Certification data: TCCA STC SH08-16; FAA STC SR02680NY

Black

13a. Certifies that the items identified above were manufactured in conformity to:		14a. ☐ CAR 571.10 Maintenance Release ☐ Other regulation specified in block 12 Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the *Canadian Aviation Regulations*.	
☒ Approved design data and are in condition for safe operation. ☐ Non approved design data specified in block 12.			
13b. Signature AD 73-04 02	13c. Approved Organization Number AMF 73-04	14b. Signature	14c. Approved Organization Number
13d. Name Jeff Clarke - AD02	13e. Date (dd/mmm/yyyy) 05 Oct 2018	14d. Name	14e. Date (dd/mmm/yyyy)

Installer Responsibilities

This certificate does not constitute authority to install.

Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.

Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.

ALPHA AVIATION

Aero Design Ltd.
9888 A Malaspina Rd. Powell River, BC, V8A 0G3
Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

In Process

Remarks

Step: 8. ✓
9. ✓
10. ✓ PO 170588
11. ✓

Aero Design Ltd.
9888 A Malaspina Rd. Powell River, BC, V8A 0G3
Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: Aft. Beam R/H No. of pieces: 1
Manufacturer: Aero Design Ltd.
Part No.: 78633-01-01 Serial/Batch No.: NA
TTSN: NA TSO: NA Rem.: NA
Work Order No.: 2017 - 104
Remaining Tasks to be Performed: See reverse.

Signature: David Marty
Date: Sept. 13/2017 Lic. No. / SCA AD 73-04 05

In Process

ALPHA AVIATION
04 OCT 2018

Aero Design
Parts Distribution Sheet

Description: AS350 RH Beams WO# 2017-104

From PO or WO #	Quantity	Description	Part Number	For WO #
2017-104	1	RH Aft Beam	78633-01-01	
17061 ~~16051~~ JC	1	Grip Tape	3M Safety Walk	

1. Approving Civil Aviation Authority/Country	2. AUTHORIZED RELEASE CERTIFICATE FORM ONE	3.Form Tracking No.
Transport Canada		2018-0229

4. Organization Name and Address	5. Work Order/Contract/Invoice
AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3	PO0021

6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
1.	Aft RH Beam	78633-01-01	1	WO 2017-104	New

12. Remarks

Certification data: TCCA STC SH08-16; FAA STC SR02680NY

Black

13a. Certifies that the items identified above were manufactured in conformity to:

☒ Approved design data and are in condition for safe operation.

☐ Non approved design data specified in block 12.

14a. ☐ CAR 571.10 Maintenance Release

☐ Other regulation specified in block 12.

Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the *Canadian Aviation Regulations*.

13b. Signature	13c. Approved Organization Number	14b. Signature	14c. Approved Organization Number
AD 73-04 02	AMF 73-04		
13d. Name	**13e. Date (dd/mmm/yyyy)**	**14d. Name**	**14e. Date (dd/mmm/yyyy)**
Jeff Clarke - AD02	11 Sept 2018		

Installer Responsibilities

This certificate does not constitute authority to install.

Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.

Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.

NORTH COAST HELICOPTERS

Aero Design Ltd.
9888 A Malaspina Rd. Powell River, BC, V8A 0G3
Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: AS350 AFT RH Beam No. of pieces: 1

Manufacturer: Aero Design

Part No.: 78633-01-01 Serial/Batch No.: NSN

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2017 - 104

Remaining Tasks to be Performed: clean up ✓, Straighten + Powder ✓

Signature: [signature]

Date: 17/12/12 Lic. No. / SCA AD 73-04 05

In Process

Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

In Process

Remarks

POWDER TO BUG

North Coast Heli
11 Sept 2018

Aero Design
Parts Distribution Sheet

Description: AS350 RH Beams

WO# 2018-116

From PO or WO #	Quantity	Description	Part Number	For WO #
2017-104	1	RH Aft Beam	78633-01-01	2017-104
17061 ~~16051~~	1	Grip Tape	3M Safety Walk	~~17061~~ 2017-104

1. Approving Civil Aviation Authority/Country	2. AUTHORIZED RELEASE CERTIFICATE FORM ONE	3.Form Tracking No.
Transport Canada		2018-0180

4. Organization Name and Address	5. Work Order/Contract/Invoice
AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3	None

6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
1.	Aft RH Beam	78633-01-01	1	WO 2017-104	New

12. Remarks

Certification data: TCCA STC SH08-16; FAA STC SR02680NY; Brazil CST 2017S07-01

13a. Certifies that the items identified above were manufactured in conformity to:

☒ Approved design data and are in condition for safe operation.

☐ Non approved design data specified in block 12.

~~14a.~~ ☐ ~~CAR 571.10 Maintenance Release~~

☐ ~~Other regulation specified in block 12~~

~~Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the *Canadian Aviation Regulations*.~~

13b. Signature	13c. Approved Organization Number	~~14b. Signature~~	~~14c. Approved Organization Number~~
AD 73-04 02	AMF 73-04		
13d. Name	**13e. Date (dd/mmm/yyyy)**	**~~14d. Name~~**	**~~14e. Date (dd/mmm/yyyy)~~**
Jeff Clarke - AD02	23 July 2018		

Installer Responsibilities

This certificate does not constitute authority to install.

Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.

Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.

Heli Sol

Aero Design Ltd.
9888 A Malaspina Rd. Powell River, BC, V8A 0G3
Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

In Process

Remarks

Step: 8. ✓
9. ✓
10. ✓ RO 17088
11. ✓

Aero Design Ltd.
9888 A Malaspina Rd. Powell River, BC, V8A 0G3
Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: Aft. Beam R/H No. of pieces: 1
Manufacturer: Aero Design Ltd.
Part No.: 28633-01-01 Serial/Batch No.: NA
TTSN: NA TSO: NA Rem.: NA
Work Order No.: 2017-~~140~~ 104 DRM
Remaining Tasks to be Performed: See reverse.

Signature: David Drury
Date: Sept. 13/2017 Lic. No. / SCA AD 73-04 05

In Process

HELI SUL

23 JULY 2018

Aero Design

Parts Distribution Sheet

Description: AS350 RH Beams

WO# 2017-104

From PO or WO #	Quantity	Description	Part Number	For WO #
2017-104	1	RH Aft Beam	78633-01-01	
17061	1	Grip Tape	3M Safety Walk	

1. Approving Civil Aviation Authority/Country	2. AUTHORIZED RELEASE CERTIFICATE FORM ONE	3.Form Tracking No.
Transport Canada		2018-0170

4. Organization Name and Address	5. Work Order/Contract/Invoice
AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3	PO 1900

6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
1.	Aft RH Beam	78633-01-01	1	WO 2017-104	New

12. Remarks

Certification data: TCCA STC SH08-16

13a. Certifies that the items identified above were manufactured in conformity to:

☒ Approved design data and are in condition for safe operation.

☐ Non approved design data specified in block 12.

14a. ☐ CAR 571.10 Maintenance Release

☐ Other regulation specified in block 12

Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the *Canadian Aviation Regulations*.

13b. Signature	13c. Approved Organization Number	14b. Signature	14c. Approved Organization Number
AD 73-04 02	AMF 73-04		
13d. Name	**13e. Date (dd/mmm/yyyy)**	**14d. Name**	**14e. Date (dd/mmm/yyyy)**
Jeff Clarke - AD02	04 July 2018		

Installer Responsibilities

This certificate does not constitute authority to install.

Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.

Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.

HORIZON HELICOPTERS

Aero Design Ltd.
9888 A Malaspina Rd. Powell River, BC, V8A 0G3
Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

In Process

Remarks

Steps: 8. ✓
9. ✓
10. ✓ po 17105
11. ✓

Aero Design Ltd.
9888 A Malaspina Rd. Powell River, BC, V8A 0G3
Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: AFT R/H Beam (AS350) No. of pieces: 1
Manufacturer: Aero Design Ltd.
Part No.: 78633-01-01 Serial/Batch No.: NA
TTSN: NA TSO: NA Rem.: NA
Work Order No.: 2017-104
Remaining Tasks to be Performed: See reverse.

Signature: David Marty
Date: Oct 27/2015 Lic. No. / SCA AO 73-04 05

In Process

HORIZON HELICOPTERS
04 JULY 2018

Aero Design
Parts Distribution Sheet

Description: AS350 RH Beams

WO# 2017-104

From PO or WO #	Quantity	Description	Part Number	For WO #
2017-104	1	RH Aft Beam	78633-01-01	
17061	1	Grip Tape	3M Safety Walk	

1. Approving Civil Aviation Authority/Country	2. AUTHORIZED RELEASE CERTIFICATE FORM ONE	3.Form Tracking No.
Transport Canada		2018-0164

4. Organization Name and Address	5. Work Order/Contract/Invoice
AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3	None

6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
1.	Aft RH Beam	78633-01-01	1	WO 2017-104	New

12. Remarks

Certification data: TCCA STC SH08-16; FAA STC SR02680NY

13a. Certifies that the items identified above were manufactured in conformity to:

☒ Approved design data and are in condition for safe operation.

☐ Non approved design data specified in block 12.

~~14a.~~ ☐ ~~CAR 571.10 Maintenance Release~~

☐ ~~Other regulation specified in block 12~~

~~Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the *Canadian Aviation Regulations*.~~

13b. Signature	13c. Approved Organization Number	~~14b. Signature~~	~~14c. Approved Organization Number~~
AD 73-04 02	AMF 73-04		
13d. Name	**13e. Date (dd/mmm/yyyy)**	~~14d. Name~~	~~14e. Date (dd/mmm/yyyy)~~
Jeff Clarke - AD02	12 June 2018		

Installer Responsibilities

This certificate does not constitute authority to install.

Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.

Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.

Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

In Process

Remarks

PAINTED 26 JUNE 2014 GC.

Aero Design Ltd.
9888 A Malaspina Rd. Powell River, BC, V8A 0G3
Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: A5350 AFT RH Beam No. of pieces: 1

Manufacturer: Aero Design

Part No.: 78633 -01-01 Serial/Batch No.: NSN

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2017 - 104

Remaining Tasks to be Performed: clean up ✓, Straighten ✓ + Powdure ✓

Signature: [signature] AD 73-04

Date: 17/12/12 Lic. No. / SCA 05

In Process

HELI PRODUCTS
26 JUNE 2017

Aero Design
Parts Distribution Sheet

Description: AS350 RH Beams

WO# 2017-104

From PO or WO #	Quantity	Description	Part Number	For WO #
2017-104	1	RH Aft Beam	78633-01-01	
16051	1	Grip Tape	3M Safety Walk	

1. Approving Civil Aviation Authority/Country	2. AUTHORIZED RELEASE CERTIFICATE FORM ONE	3.Form Tracking No.
Transport Canada		2018-0137

4. Organization Name and Address	5. Work Order/Contract/Invoice
AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3	PO 56147

6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
1.	Aft RH Beam	78633-01-01	1	WO 2017-104	New

12. Remarks

Certification data: TCCA STC SH08-16; FAA STC SR02680NY

Black

13a. Certifies that the items identified above were manufactured in conformity to:

☒ Approved design data and are in condition for safe operation.

☐ Non approved design data specified in block 12.

14a. ☐ CAR 571.10 Maintenance Release

☐ Other regulation specified in block 12

Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the *Canadian Aviation Regulations*.

13b. Signature	13c. Approved Organization Number	14b. Signature	14c. Approved Organization Number
Jeff Clarke. AD 73-04 02	AMF 73-04		
13d. Name	**13e. Date (dd/mmm/yyyy)**	**14d. Name**	**14e. Date (dd/mmm/yyyy)**
Jeff Clarke - AD02	12 June 2018		

Installer Responsibilities

This certificate does not constitute authority to install.

Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.

Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.

ROTOR - LIFT

Aero Design Ltd.
9888 A Malaspina Rd. Powell River, BC, V8A 0G3
Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

In Process

Remarks

Powder PO 18019

Aero Design Ltd.
9888 A Malaspina Rd. Powell River, BC, V8A 0G3
Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: AS350 AFT RH Beam No. of pieces: 1

Manufacturer: Aero Design

Part No.: 76633-01-01 Serial/Batch No.: NSN

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2017-104

Remaining Tasks to be Performed: Clean up ✓, Straighten + Powder ✓

Signature: [signature] AD 73-04 05

Date: 17/12/12 Lic. No. / SCA

In Process

ROTOR- LIFT
12 JUNE 2018

Aero Design
Parts Distribution Sheet

Description: AS350 RH Beams

WO# 2017-104

From PO or WO #	Quantity	Description	Part Number	For WO #
2017-104	1	RH Aft Beam	78633-01-01	
16051	1	Grip Tape	3M Safety Walk	

1. Approving Civil Aviation Authority/Country	2. AUTHORIZED RELEASE CERTIFICATE FORM ONE	3.Form Tracking No.
Transport Canada		2018-0118

4. Organization Name and Address	5. Work Order/Contract/Invoice
AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3	None

6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
1.	Aft RH Beam	78633-01-01	1	WO 2017-104	New

12. Remarks

Certification data: TCCA STC SH08-16

13a. Certifies that the items identified above were manufactured in conformity to:

☒ Approved design data and are in condition for safe operation.

☐ Non approved design data specified in block 12.

14a. ☐ CAR 571.10 Maintenance Release

☐ Other regulation specified in block 12

Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the *Canadian Aviation Regulations*.

13b. Signature	13c. Approved Organization Number	14b. Signature	14c. Approved Organization Number
AD 73-04 02	AMF 73-04		
13d. Name	**13e. Date (dd/mmm/yyyy)**	**14d. Name**	**14e. Date (dd/mmm/yyyy)**
Jeff Clarke - AD02	24 May 2018		

Installer Responsibilities

This certificate does not constitute authority to install.

Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.

Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.

KOOTENAY VALLEY HELI

Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

In Process

Remarks

Steps: 8. ✓
9. ✓
10. ✓ P0 17 195
11. ✓

Aero Design Ltd.
9888 A Malaspina Rd. Powell River, BC, V8A 0G3
Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: Aft. R/H Beam (A5350) No. of pieces: 1
Manufacturer: Aero Design Ltd.
Part No.: 78633-01-01 Serial/Batch No.: NA
TTSN: NA TSO: NA Rem.: NA
Work Order No.: 2017-104
Remaining Tasks to be Performed: See reverse

Signature: [signature]
Date: Oct 27/2017 Lic. No. / SCA

AD 73-04 05

In Process

KOOTENAY VALLEY HELI
24 MAY 2018

Aero Design

Parts Distribution Sheet

Description: AS350 RH Beams

WO# 2017-104

From PO or WO #	Quantity	Description	Part Number	For WO #
2017-104	1	RH Aft Beam	78633-01-01	
16051	1	Grip Tape	3M Safety Walk	

1. Approving Civil Aviation Authority/Country	2. AUTHORIZED RELEASE CERTIFICATE FORM ONE	3.Form Tracking No.
Transport Canada		2018-0103
4. Organization Name and Address		5. Work Order/Contract/Invoice
AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3		None

6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
1.	Aft RH Beam	78633-01-01	1	WO 2017-104	New

12. Remarks

Certification data: TCCA STC SH08-16

13a. Certifies that the items identified above were manufactured in conformity to:

☒ Approved design data and are in condition for safe operation.

☐ Non approved design data specified in block 12.

~~14a.~~ ☐ CAR 571.10 Maintenance Release

☐ Other regulation specified in block 12

~~Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the *Canadian Aviation Regulations*.~~

13b. Signature	13c. Approved Organization Number	~~14b. Signature~~	~~14c. Approved Organization Number~~
AD 73-04 02	AMF 73-04		
13d. Name	**13e. Date (dd/mmm/yyyy)**	~~14d. Name~~	~~14e. Date (dd/mmm/yyyy)~~
Jeff Clarke - AD02	09 May 2018		

Installer Responsibilities

This certificate does not constitute authority to install.

Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.

Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.

WEST COAST HELICOPTERS

Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

In Process

Remarks

Powder Coat Po 17105

Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: AS350 AFT RH Beam No. of pieces: 1

Manufacturer: Aero Design

Part No.: TB633-01-01 Serial/Batch No.: NSN

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2017-104

Remaining Tasks to be Performed: clean up ✓, straighten ✓ + Powder ✓

AD 73-04 05

Signature: David Monty

Date: 17/12/12 Lic. No. / SCA

In Process

WEST COAST HELI

09 MAY 2018

Aero Design

Parts Distribution Sheet

Description: AS350 RH Beams

WO# 2017-104

From PO or WO #	Quantity	Description	Part Number	For WO #
2017-104	1	RH Aft Beam	78633-01-01	
16051	1	Grip Tape	3M Safety Walk	

1. Approving Civil Aviation Authority/Country	2. AUTHORIZED RELEASE CERTIFICATE FORM ONE	3.Form Tracking No.
Transport Canada		2018-0101
4. Organization Name and Address		5. Work Order/Contract/Invoice
AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3		PO 0011

6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
1.	Aft RH Beam	78633-01-01	1	WO 2017-104	New

12. Remarks

Certification data: TCCA STC SH08-16

13a. Certifies that the items identified above were manufactured in conformity to:	14a. ☐ CAR 571.10 Maintenance Release ☐ Other regulation specified in block 12
☒ Approved design data and are in condition for safe operation. ☐ Non approved design data specified in block 12.	Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the *Canadian Aviation Regulations*.

13b. Signature	13c. Approved Organization Number	14b. Signature	14c. Approved Organization Number
AD 73-04 02	AMF 73-04		
13d. Name	**13e. Date (dd/mmm/yyyy)**	**14d. Name**	**14e. Date (dd/mmm/yyyy)**
Jeff Clarke - AD02	08 May 2018		

Installer Responsibilities

This certificate does not constitute authority to install.

Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.

Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.

NORTH COAST HELICOPTERS

Aero Design Ltd.
9888 A Malaspina Rd. Powell River, BC, V8A 0G3
Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

In Process

Remarks

POWDER PO 15019

Aero Design Ltd.
9888 A Malaspina Rd. Powell River, BC, V8A 0G3
Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: AS350 AFT RH Beam No. of pieces: 1
Manufacturer: Aero Design
Part No.: 78633 -01 -01 Serial/Batch No.: NSN
TTSN: N/A TSO: N/A Rem.: N/A
Work Order No.: 2017 - 104
Remaining Tasks to be Performed: Clean up ✓, straighten ✓ + Powder ✓

Signature: David Marty
Date: 17/12/12 Lic. No. / SCA AD 73-04 05

In Process

NORTH COAST HELICOPTERS
08 MAY 2018

Aero Design
Parts Distribution Sheet

Description: AS350 RH Beams

WO# 2017-104

From PO or WO #	Quantity	Description	Part Number	For WO #
2017-104	1	RH Aft Beam	78633-01-01	
17061	1	Grip Tape	3M Safety Walk	

1. Approving Civil Aviation Authority/Country	2. AUTHORIZED RELEASE CERTIFICATE FORM ONE	3.Form Tracking No.
Transport Canada		2018-0098

4. Organization Name and Address	5. Work Order/Contract/Invoice
AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3	None

6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
1.	Aft RH Beam	78633-01-01	1	WO 2017-104	New

12. Remarks

Certification data: TCCA STC SH08-16; FAA STC SR02680NY

Black

13a. Certifies that the items identified above were manufactured in conformity to:	14a. ~~CAR 571.10 Maintenance Release~~
☒ Approved design data and are in condition for safe operation.	~~☐ Other regulation specified in block 12~~
☐ Non approved design data specified in block 12.	~~Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the *Canadian Aviation Regulations*.~~

13b. Signature	13c. Approved Organization Number	~~14b. Signature~~	~~14c. Approved Organization Number~~
AD 73-04 02	AMF 73-04		
13d. Name	**13e. Date (dd/mmm/yyyy)**	~~14d. Name~~	~~14e. Date (dd/mmm/yyyy)~~
Jeff Clarke - AD02	08 May 2018		

Installer Responsibilities

This certificate does not constitute authority to install.

Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.

Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.

ALPHA AVIATION

Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

In Process

Remarks

Step: 8. ✓

9. ✓

10. ✓ PO 17088

11. ✓

Aero Design Ltd.
9888 A Malaspina Rd. Powell River, BC, V8A 0G3
Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: Aft. Beam R/H No. of pieces: 1
Manufacturer: Aero Design Ltd.
Part No.: 78633-01-01 Serial/Batch No.: NA
TTSN: NA TSO: NA Rem.: NA
Work Order No.: 2017-104
Remaining Tasks to be Performed: See reverse.

Signature: [signature]
Date: Sept. 13/2017 Lic. No. / SCA AO 73-04 05

In Process

ALPHA AVIATION
05 MAY 2018

Aero Design

Parts Distribution Sheet

Description: AS350 RH Beams

WO# 2017-104

From PO or WO #	Quantity	Description	Part Number	For WO #
2017-104	1	RH Aft Beam	78633-01-01	
16051	1	Grip Tape	3M Safety Walk	

1. Approving Civil Aviation Authority/Country	2. AUTHORIZED RELEASE CERTIFICATE FORM ONE	3.Form Tracking No.
Transport Canada		2018-0030

4. Organization Name and Address	5. Work Order/Contract/Invoice
AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3	WO 2017-104

6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
1.	Aft RH Beam	78633-01-01	1	N/A	New

12. Remarks

13a. Certifies that the items identified above were manufactured in conformity to:

☒ Approved design data and are in condition for safe operation.

☐ Non approved design data specified in block 12.

~~14a.~~ ☐ CAR 571.10 Maintenance Release

☐ Other regulation specified in block 12

Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the *Canadian Aviation Regulations*.

13b. Signature	13c. Approved Organization Number	~~14b. Signature~~	~~14c. Approved Organization Number~~
AD 73-04 02	AMF 73-04		
13d. Name	**13e. Date (dd/mmm/yyyy)**	~~14d. Name~~	~~14e. Date (dd/mmm/yyyy)~~
Jeff Clarke - AD02	08 Feb 2018		

Installer Responsibilities

This certificate does not constitute authority to install.

Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.

Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.

Rotor-Lift Aviation

Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

In Process

Remarks

Steps: 8. /

9. ✓

10. ✓ Ro 1716S

11.

Aero Design Ltd.
9888 A Malaspina Rd. Powell River, BC, V8A 0G3
Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: Aft. R/H Beam (AS350) No. of pieces: 1
Manufacturer: Aero Design Ltd.
Part No.: 78633-01-01 Serial/Batch No.: NA
TTSN: NA TSO: NA Rem.: NA
Work Order No.: 2017-104
Remaining Tasks to be Performed: See reverse.

Signature:
Date: Oct 27/2017 Lic. No. / SCA ~~NO 73-04~~ 05

In Process

Rotor-Lift Aviation
07 Feb 2018

Aero Design

Parts Distribution Sheet

Description: AS350 RH Beams

WO# 2017-104

From PO or WO #	Quantity	Description	Part Number	For WO #
2017-104	1	RH Aft Beam	78633-01-01	
16051	1	Grip Tape	3M Safety Walk	

1. Approving Civil Aviation Authority/Country	2. AUTHORIZED RELEASE CERTIFICATE FORM ONE	3.Form Tracking No.
Transport Canada		2018-0001

4. Organization Name and Address	5. Work Order/Contract/Invoice
AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3	WO 2017-104

6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
1.	Aft RH Beam	78633-01-01	1	N/A	New

12. Remarks

13a. Certifies that the items identified above were manufactured in conformity to:

☒ Approved design data and are in condition for safe operation.

☐ Non approved design data specified in block 12.

~~14a.~~ ☐ ~~CAR 571.10 Maintenance Release~~

☐ ~~Other regulation specified in block 12~~

~~Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the *Canadian Aviation Regulations*.~~

13b. Signature	13c. Approved Organization Number	~~14b. Signature~~	~~14c. Approved Organization Number~~
Jeff Clarke AD 73-04 02	AMF 73-04		
13d. Name	**13e. Date (dd/mmm/yyyy)**	**~~14d. Name~~**	**~~14e. Date (dd/mmm/yyyy)~~**
Jeff Clarke - AD02	04 Jan 2018		

Installer Responsibilities

This certificate does not constitute authority to install.

Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.

Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.

Access Helicopters

Aero Design Ltd.
9888 A Malaspina Rd. Powell River, BC, V8A 0G3
Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

In Process

Remarks

Steps: 8, ✓
9, ✓
10, ✓ Po 17105
11, ✓

Aero Design Ltd.
9888 A Malaspina Rd. Powell River, BC, V8A 0G3
Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: AFT RH Beam (AS350) No. of pieces: 1
Manufacturer: Aero Design Ltd.
Part No.: 78633-01-01 Serial/Batch No.: NA
TTSN: NA TSO: NA Rem.: NA
Work Order No.: 2017-104
Remaining Tasks to be Performed: See reverse

Signature: [signature]
Date: Oct 27/2017 Lic. No. / SCA AD 73-04 05

In Process

Access Helicopters
04 JAN 2018

Aero Design
Parts Distribution Sheet

Description: AS350 RH Beams

WO# 2017-104

From PO or WO #	Quantity	Description	Part Number	For WO #
2017-104	1	RH Aft Beam	78633-01-01	
16051	1	Grip Tape	3M Safety Walk	

1. Approving Civil Aviation Authority/Country	2. AUTHORIZED RELEASE CERTIFICATE FORM ONE	3.Form Tracking No.
Transport Canada		2017-0481

4. Organization Name and Address	5. Work Order/Contract/Invoice
AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3	WO 2017-104

6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
1.	Aft RH Beam	78633-01-01	1	N/A	New

12. Remarks

Black

13a. Certifies that the items identified above were manufactured in conformity to:

☒ Approved design data and are in condition for safe operation.

☐ Non approved design data specified in block 12.

~~14a.~~ ☐ ~~CAR 571.10 Maintenance Release~~

☐ ~~Other regulation specified in block 12~~

~~Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the *Canadian Aviation Regulations*.~~

13b. Signature	13c. Approved Organization Number	~~14b. Signature~~	~~14c. Approved Organization Number~~
Jeff Clarke 73-04	AMF 73-04		
13d. Name	**13e. Date (dd/mmm/yyyy)**	~~14d. Name~~	~~14e. Date (dd/mmm/yyyy)~~
Jeff Clarke - AD02	19 Dec 2017		

Installer Responsibilities

This certificate does not constitute authority to install.

Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.

Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.

SOLOY HELICOPTERS

Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

In Process

Remarks

Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: AS350 AFT RH Beams No. of pieces: 1

Manufacturer: Aero Design

Part No.: 78633-01-01 Serial/Batch No.: NSN

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2017-104

Remaining Tasks to be Performed: clean up, Straighten + Powder ✓

Signature:

Date: 17/12/12 Lic. No. / SCA

AD 73-04 05

In Process

Solcy Helicopters
19 DEC 2017

Aero Design

Parts Distribution Sheet

Description: AS350 RH Beams

WO# 2017-104

From PO or WO #	Quantity	Description	Part Number	For WO #
2017-104	1	RH Aft Beam	78633-01-01	
16051	1	Grip Tape	3M Safety Walk	

1. Approving Civil Aviation Authority/Country	2. AUTHORIZED RELEASE CERTIFICATE FORM ONE	3.Form Tracking No.
Transport Canada		2017-0457

4. Organization Name and Address	5. Work Order/Contract/Invoice
AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3	WO 2017-104

6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
1.	Aft RH Beam	78633-01-01	1	N/A	New

12. Remarks

13a. Certifies that the items identified above were manufactured in conformity to:

☒ Approved design data and are in condition for safe operation.

☐ Non approved design data specified in block 12.

~~14a.~~ ☐ CAR 571.10 Maintenance Release

☐ Other regulation specified in block 12

~~Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the *Canadian Aviation Regulations*.~~

13b. Signature	13c. Approved Organization Number	~~14b. Signature~~	~~14c. Approved Organization Number~~
AD 73-04 02	AMF 73-04		
13d. Name	**13e. Date (dd/mmm/yyyy)**	**~~14d. Name~~**	**~~14e. Date (dd/mmm/yyyy)~~**
Jeff Clarke - AD02	06 Dec 2017		

Installer Responsibilities

This certificate does not constitute authority to install.

Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.

Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.

Access Helicopters

Aero Design Ltd.
9888 A Malaspina Rd. Powell River, BC, V8A 0G3
Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

In Process

Remarks

Step: 8. ✓
9. ✓
10. ✓ PO 17088
11. ✓

Aero Design Ltd.
9888 A Malaspina Rd. Powell River, BC, V8A 0G3
Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: Aft. Beam R/H No. of pieces: 1
Manufacturer: Aero Design Ltd.
Part No.: 78633-01-01 Serial/Batch No.: NA
TTSN: NA TSO: NA Rem.: NA
Work Order No.: 2017-104
Remaining Tasks to be Performed: See reverse.

Signature: [signature]
Date: Sept. 13/2017 Lic. No. / SCA AD 73-04 05

In Process

Access Helicopters
06 Dec 2017

Aero Design
Parts Distribution Sheet

Description: AS350 RH Beams WO# 2017-104

From PO or WO #	Quantity	Description	Part Number	For WO #
2017-104	1	RH Aft Beam	78633-01-01	
16051	1	Grip Tape	3M Safety Walk	

1. Approving Civil Aviation Authority/Country	2. AUTHORIZED RELEASE CERTIFICATE FORM ONE				3.Form Tracking No.
Transport Canada					2017-0430
4. Organization Name and Address					5. Work Order/Contract/Invoice
AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					WO 2017-104
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
1.	Aft RH Beam	78633-01-01	1	N/A	New
12. Remarks					

13a. Certifies that the items identified above were manufactured in conformity to:	14a. ☐ CAR 571.10 Maintenance Release ☐ Other regulation specified in block 12
☒ Approved design data and are in condition for safe operation. ☐ Non approved design data specified in block 12.	Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the *Canadian Aviation Regulations*.
13b. Signature AD 73-04 02	13c. Approved Organization Number AMF 73-04
13d. Name Jeff Clarke - AD02	13e. Date (dd/mmm/yyyy) 22 Nov 2017

14b. Signature	14c. Approved Organization Number
14d. Name	14e. Date (dd/mmm/yyyy)

Installer Responsibilities

This certificate does not constitute authority to install.

Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.

Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.

SELKIRK MOUNTAIN HELI

Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

In Process

Remarks

Steps: 8, ✓

9, ✓

10, ✓

11, ✓

Aero Design Ltd.
9888 A Malaspina Rd. Powell River, BC, V8A 0G3
Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: Aft. R/H Beam (AS350) No. of pieces: 1
Manufacturer: Aero Design Ltd.
Part No.: 7863-01-01 Serial/Batch No.: NA
TTSN: NA TSO: NA Rem.: NA
Work Order No.: 2017-104
Remaining Tasks to be Performed: See reverse.

Signature: David Doherty
Date: Oct 27/2017 Lic. No. / SCA AO 73-04 05

In Process

Selkirk Mountain Heli
22 Nov 2017

Aero Design

Parts Distribution Sheet

Description: AS350 RH Beams

WO# 2017-104

From PO or WO #	Quantity	Description	Part Number	For WO #
2017-104	1	RH Aft Beam	78633-01-01	
16051	1	Grip Tape	3M Safety Walk	

1. Approving Civil Aviation Authority/Country	2. AUTHORIZED RELEASE CERTIFICATE FORM ONE	3.Form Tracking No.
Transport Canada		2017-0414

4. Organization Name and Address	5. Work Order/Contract/Invoice
AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3	WO 2017-104

6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
1.	Aft RH Beam	78633-01-01	1	N/A	New

12. Remarks

13a. Certifies that the items identified above were manufactured in conformity to:

☒ Approved design data and are in condition for safe operation.

☐ Non approved design data specified in block 12.

~~14a.~~ ☐ CAR 571.10 Maintenance Release

☐ Other regulation specified in block 12

Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the *Canadian Aviation Regulations*.

13b. Signature	13c. Approved Organization Number	~~14b. Signature~~	~~14c. Approved Organization Number~~
AD 73-04 02	AMF 73-04		
13d. Name	**13e. Date (dd/mmm/yyyy)**	~~14d. Name~~	~~14e. Date (dd/mmm/yyyy)~~
Jeff Clarke - AD02	08 Nov 2017		

Installer Responsibilities

This certificate does not constitute authority to install.

Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.

Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.

TURISMO BURRACO

Aero Design Ltd.
9888 A Malaspina Rd. Powell River, BC, V8A 0G3
Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

In Process

Remarks

Steps; 8. ✓
9. ✓
10. PO 17088
11.

Aero Design Ltd.
9888 A Malaspina Rd. Powell River, BC, V8A 0G3
Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: Aft. Beam R/H No. of pieces: 1
Manufacturer: Aero Design Ltd.
Part No.: 78633-01-01 Serial/Batch No.: NA
TTSN: NA TSO: NA Rem.: NA
Work Order No.: 2017-104
Remaining Tasks to be Performed: See reverse.

Signature: David Marty AD 73-04
Date: Sept. 13/2017 Lic. No. / SCA 05

In Process

TURISMO BURRACO
05 NOV 2017

Aero Design

Parts Distribution Sheet

Description: AS350 RH Beams

WO# 2017-104

From PO or WO #	Quantity	Description	Part Number	For WO #
2017-104	1	RH Aft Beam	78633-01-01	
16051	1	Grip Tape	3M Safety Walk	

1. Approving Civil Aviation Authority/Country	2. AUTHORIZED RELEASE CERTIFICATE FORM ONE	3.Form Tracking No.
Transport Canada		2017-0390

4. Organization Name and Address	5. Work Order/Contract/Invoice
AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3	WO 2017-104

6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
1.	Aft RH Beam	78633-01-01	1	N/A	New

12. Remarks

13a. Certifies that the items identified above were manufactured in conformity to:

☒ Approved design data and are in condition for safe operation.

☐ Non approved design data specified in block 12.

14a. ☐ CAR 571.10 Maintenance Release

☐ Other regulation specified in block 12

Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the *Canadian Aviation Regulations*.

13b. Signature	13c. Approved Organization Number	14b. Signature	14c. Approved Organization Number
AD 73-04 02	AMF 73-04		
13d. Name	**13e. Date (dd/mmm/yyyy)**	**14d. Name**	**14e. Date (dd/mmm/yyyy)**
Jeff Clarke - AD02	17 Oct 2017		

Installer Responsibilities

This certificate does not constitute authority to install.

Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.

Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.

Zimmer Air Services

Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

In Process

Remarks

Aero Design Ltd.
9888 A Malaspina Rd. Powell River, BC, V8A 0G3
Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: A350 AFT RH Beam No. of pieces: 1

Manufacturer: Aero Design Ltd.

Part No.: 78633-01-01 Serial/Batch No.: NA

TTSN: NA TSO: NA Rem.: NA

Work Order No.: 2017-104-4

Remaining Tasks to be Performed: Straighten, drill, clean up, inspect, powder coat.

Signature: [signature]

Date: August 21 / 2017 Lic. No. / SCA NO 73-04 05

In Process

ZIMMER AIR

16/10/2017

Aero Design

Parts Distribution Sheet

Description: AS350 RH Beams

WO# 2017-104

From PO or WO #	Quantity	Description	Part Number	For WO #
2017-104	1	RH Aft Beam	78633-01-01	
16051	1	Grip Tape	3M Safety Walk	

1. Approving Civil Aviation Authority/Country	2. AUTHORIZED RELEASE CERTIFICATE FORM ONE	3.Form Tracking No.
Transport Canada		2017-0384
4. Organization Name and Address		5. Work Order/Contract/Invoice
AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3		WO 2017-104

6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
1.	Aft RH Beam	78633-01-01	1	N/A	New

12. Remarks

13a. Certifies that the items identified above were manufactured in conformity to:

☒ Approved design data and are in condition for safe operation.

☐ Non approved design data specified in block 12.

~~14a.~~ ☐ CAR 571.10 Maintenance Release

☐ Other regulation specified in block 12

Certifies that unless ~~otherwise~~ specified in block ~~12~~, the work identified in block 11 and ~~described~~ in block 12, has been performed in ~~compliance~~ with the ~~Canadian~~ *Aviation Regulations*.

13b. Signature	13c. Approved Organization Number	~~14b. Signature~~	~~14c. Approved Organization Number~~
AD 73-04 02	AMF 73-04		
13d. Name	**13e. Date (dd/mmm/yyyy)**	~~14d. Name~~	~~14e. Date (dd/mmm/yyyy)~~
Jeff Clarke - AD02	12 Oct 2017		

Installer Responsibilities

This certificate does not constitute authority to install.

Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.

Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.

BIG HORN HELICOPTERS

Aero Design Ltd.
9888 A Malaspina Rd. Powell River, BC, V8A 0G3
Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: AFT Beam R/H No. of pieces: 1
Manufacturer: Aero Design Ltd.
Part No.: 78633-01-01 Serial/Batch No.: NA
TTSN: NA TSO: NA Rem.: NA
Work Order No.: 2017-104
Remaining Tasks to be Performed: Clean up, straighten, inspect, powder coat.

Signature: David Marty
Date: Oct 10/2017 Lic. No. / SCA

AD 73-04 66

In Process

Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

In Process

Remarks

PAINTED 11 OCT 2017 gc

Big Horn Heli
12/10/17

Aero Design
Parts Distribution Sheet

Description: AS350 RH Beams

WO# 2017-104

From PO or WO #	Quantity	Description	Part Number	For WO #
2017-104	1	RH Aft Beam	78633-01-01	
16051	1	Grip Tape	3M Safety Walk	

1. Approving Civil Aviation Authority/Country	2. AUTHORIZED RELEASE CERTIFICATE FORM ONE	3.Form Tracking No.
Transport Canada		2017-0341
4. Organization Name and Address		5. Work Order/Contract/Invoice
AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3		WO 2017-104

6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
1.	Aft RH Beam	78633-01-01	1	N/A	New

12. Remarks

13a. Certifies that the items identified above were manufactured in conformity to:	14a. ☐ CAR 571.10 Maintenance Release ☐ Other regulation specified in block 12
☒ Approved design data and are in condition for safe operation. ☐ Non approved design data specified in block 12.	Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the *Canadian Aviation Regulations*.

13b. Signature	13c. Approved Organization Number	14b. Signature	14c. Approved Organization Number
AD 73-04 02	AMF 73-04		
13d. Name	**13e. Date (dd/mmm/yyyy)**	**14d. Name**	**14e. Date (dd/mmm/yyyy)**
Jeff Clarke - AD02	11 Sep 2017		

Installer Responsibilities

This certificate does not constitute authority to install.

Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.

Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.

SOLOY HELICOPTERS

Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

In Process

Remarks

Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: AFT RH BEAM (AS350) No. of pieces: 36

Manufacturer: AERO DESIGN LTD

Part No.: 76633-01-01 Serial/Batch No.: PO 17050 (Tube)

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2017-104

Remaining Tasks to be Performed: MACHINING, WELDING, MACHINING, WELDING, INSPECTION, POWDER COAT

Signature:

Date: 24 May 2017 Lic. No. / SCA ADO7

In Process

Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

In Process

Remarks

Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: A330 AFR/H Beam No. of pieces: 1

Manufacturer: Aero Design Ltd.

Part No.: 78633-01-01 Serial/Batch No.: NA

TTSN: NA TSO: NA Rem.: NA

Work Order No.: 2017-104-5

Remaining Tasks to be Performed: Straighten, drill, clean up, inspect, powder coat.

Signature:

Date: August 21/2017 Lic. No. / SCA

~~NO~~ ~~73-04~~ ~~05~~

In Process

Aero Design

Parts Distribution Sheet

Description: AS350 RH Beams WO#

From PO or WO #	Quantity	Description	Part Number	For WO #
2017-104	1	RH Aft Beam	78633-01-01	
16051	1	Grip Tape	3M Safety Walk	

1. Approving Civil Aviation Authority/Country	2. AUTHORIZED RELEASE CERTIFICATE FORM ONE	3.Form Tracking No.
Transport Canada		2017-0329

4. Organization Name and Address	5. Work Order/Contract/Invoice
AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3	WO 2017-104

6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
1.	Aft RH Beam	78633-01-01	1	N/A	New

12. Remarks

Red

13a. Certifies that the items identified above were manufactured in conformity to:

☒ Approved design data and are in condition for safe operation.

☐ Non approved design data specified in block 12.

14a. ☐ CAR 571.10 Maintenance Release

☐ Other regulation specified in block 12

Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the *Canadian Aviation Regulations*.

13b. Signature	13c. Approved Organization Number	14b. Signature	14c. Approved Organization Number
AD 73-04 02	AMF 73-04		
13d. Name	**13e. Date (dd/mmm/yyyy)**	**14d. Name**	**14e. Date (dd/mmm/yyyy)**
Jeff Clarke - AD02	07 Sep 2017		

Installer Responsibilities

This certificate does not constitute authority to install.

Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.

Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.

BLACKCOMB HELI

Aero Design Ltd.
9888 A Malaspina Rd. Powell River, BC, V8A 0G3
Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

In Process

Remarks

Steps: 8. ✓
9. ✓
10. ✓
11. ✓

Powder Red 17074

Aero Design Ltd.
9888 A Malaspina Rd. Powell River, BC, V8A 0G3
Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: AFT. R/H Beam No. of pieces: 1
Manufacturer: Aero Design LTd.
Part No.: 78633-01-01 Serial/Batch No.: NA
TTSN: NA TSO: NA Rem.: NA
Work Order No.: 2017-104
Remaining Tasks to be Performed: See Back

Signature:
Date: Aug 9/2017 Lic. No. / SCA

AD 73-04 05

In Process

Aero Design

Parts Distribution Sheet

Description: AS350 RH Beams WO#

From PO or WO #	Quantity	Description	Part Number	For WO #
2017-104	1	RH Aft Beam	78633-01-01	
16051	1	Grip Tape	3M Safety Walk	

1. Approving Civil Aviation Authority/Country	2. AUTHORIZED RELEASE CERTIFICATE FORM ONE	3.Form Tracking No.
Transport Canada		2017-0311

4. Organization Name and Address	5. Work Order/Contract/Invoice
AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3	WO 2017-104

6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
1.	Aft RH Beam	78633-01-01	1	N/A	New

12. Remarks

13a. Certifies that the items identified above were manufactured in conformity to:

☒ Approved design data and are in condition for safe operation.

☐ Non approved design data specified in block 12.

~~14a.~~ ☐ ~~CAR 571.10 Maintenance Release~~

☐ ~~Other regulation specified in block 12~~

~~Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the *Canadian Aviation Regulations*.~~

13b. Signature	13c. Approved Organization Number	~~14b. Signature~~	~~14c. Approved Organization Number~~
JC AD 73-04 02	AMF 73-04		
13d. Name	**13e. Date (dd/mmm/yyyy)**	~~14d. Name~~	~~14e. Date (dd/mmm/yyyy)~~
Jeff Clarke - AD02	12 Aug 2017		

Installer Responsibilities

This certificate does not constitute authority to install.

Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.

Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.

BLACKCOMB HELICOPTERS

Aero Design Ltd.
9888 A Malaspina Rd. Powell River, BC, V8A 0G3
Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

In Process

Remarks

Step: 8. ✓
9. ✓
10. ✓
11. ✓

PAINTED 11 AUG 2017 JC.

Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: AFT. Beam R/H No. of pieces: 1

Manufacturer: Aero Design Ltd.

Part No.: 78633-01-01 Serial/Batch No.: NA

TTSN: NA TSO: NA Rem.: NA

Work Order No.: 2017-104

Remaining Tasks to be Performed: See Back.

Signature: David Marty

Date: Aug 11/2017 Lic. No. / SCA AD 73-04

In Process

Blackcomb Heli
12/08/17

Aero Design

Parts Distribution Sheet

Description: AS350 RH Beams WO#

From PO or WO #	Quantity	Description	Part Number	For WO #
2017-104	1	RH Aft Beam	78633-01-01	
16051	1	Grip Tape	3M Safety Walk	

1. Approving Civil Aviation Authority/Country	2. AUTHORIZED RELEASE CERTIFICATE FORM ONE	3.Form Tracking No.
Transport Canada		2017-0299

4. Organization Name and Address	5. Work Order/Contract/Invoice
AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3	WO 2017-104

6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
1.	Aft RH Beam	78633-01-01	1	N/A	New

12. Remarks

Black

13a. Certifies that the items identified above were manufactured in conformity to:

☒ Approved design data and are in condition for safe operation.

☐ Non approved design data specified in block 12.

~~14a.~~ ☐ CAR 571.10 Maintenance Release

☐ Other regulation specified in block 12

Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the *Canadian Aviation Regulations*.

13b. Signature	13c. Approved Organization Number	~~14b. Signature~~	~~14c. Approved Organization Number~~
AD 73-04 02	AMF 73-04		
13d. Name	**13e. Date (dd/mmm/yyyy)**	~~14d. Name~~	~~14e. Date (dd/mmm/yyyy)~~
Jeff Clarke - AD02	09 Aug 2017		

Installer Responsibilities

This certificate does not constitute authority to install.

Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.

Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.

WTS AVIATION

WTS AVIATION
09 AUG 2017

Aero Design
Parts Distribution Sheet

Description: AS350 RH Beams WO#

From PO or WO #	Quantity	Description	Part Number	For WO #
2017-104	1	RH Aft Beam	78633-01-01	
16051	1	Grip Tape	3M Safety Walk	

1. Approving Civil Aviation Authority/Country	2. AUTHORIZED RELEASE CERTIFICATE FORM ONE	3.Form Tracking No.
Transport Canada		2019-0178

4. Organization Name and Address	5. Work Order/Contract/Invoice
AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3	PO N352SC_5-19_1

6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
1.	Aft RH Beam	78633-01-01	1	WO 2017-104	New

12. Remarks

Certification data: TCCA STC SH08-16; FAA STC SR02680NY; EASA STC 10060494

13a. Certifies that the items identified above were manufactured in conformity to:

☒ Approved design data and are in condition for safe operation.

☐ Non approved design data specified in block 12.

14a. ☐ CAR 571.10 Maintenance Release

☐ Other regulation specified in block 12

Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the *Canadian Aviation Regulations*.

13b. Signature	13c. Approved Organization Number	14b. Signature	14c. Approved Organization Number
AD 73-04 02	AMF 73-04		
13d. Name	**13e. Date (dd/mmm/yyyy)**	**14d. Name**	**14e. Date (dd/mmm/yyyy)**
Jeff Clarke - AD02	10 June 2019		

Installer Responsibilities

This certificate does not constitute authority to install.

Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.

Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.

SOUTH COAST

Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

In Process

Remarks

Powder Co 15019

Aero Design Ltd.
9888 A Malaspina Rd. Powell River, BC, V8A 0G3
Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: AS350 AFT RH Beam No. of pieces: 1
Manufacturer: Aero Design
Part No.: 78633 -01 -01 Serial/Batch No.: NSN
TTSN: N/A TSO: N/A Rem.: N/A
Work Order No.: 2017 -104
Remaining Tasks to be Performed: clean up, Straighten + Powder ✓ ✓

AD
Signature: [signature] 73-04
Date: 17/12/12 Lic. No. / SCA 05

In Process

South Coast
10 June 2019

Aero Design
Parts Distribution Sheet

Description: AS350 RH Beams WO#

From PO or WO #	Quantity	Description	Part Number	For WO #
2017-104	1	RH Aft Beam	78633-01-01	
17061	1	Grip Tape	3M Safety Walk	

1. Approving Civil Aviation Authority/Country	2. AUTHORIZED RELEASE CERTIFICATE FORM ONE	3.Form Tracking No.
Transport Canada		2019-0205

4. Organization Name and Address	5. Work Order/Contract/Invoice
AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3	PO Jason

6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
1.	Aft RH Beam	78633-01-01	1	WO 2017-104	New

12. Remarks

Certification data: TCCA STC SH08-16; FAA STC SR02680NY; EASA STC 10060494

13a. Certifies that the items identified above were manufactured in conformity to:

☒ Approved design data and are in condition for safe operation.

☐ Non approved design data specified in block 12.

14a. ☐ CAR 571.10 Maintenance Release

☐ Other regulation specified in block 12

Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the *Canadian Aviation Regulations*.

13b. Signature	13c. Approved Organization Number	14b. Signature	14c. Approved Organization Number
AD 73-04 02	AMF 73-04		
13d. Name	**13e. Date (dd/mmm/yyyy)**	**14d. Name**	**14e. Date (dd/mmm/yyyy)**
Jeff Clarke - AD02	26 June 2019		

Installer Responsibilities

This certificate does not constitute authority to install.

Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.

Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.

WANDERING WHEELS

Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

In Process

Remarks

POWDER PO 18019

Aero Design Ltd.
9888 A Malaspina Rd. Powell River, BC, V8A 0G3
Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: AS350 AFT RH Beam No. of pieces: 1

Manufacturer: Aero Design

Part No.: 7863 3-01-01 Serial/Batch No.: NSN

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2017 - 104

Remaining Tasks to be Performed: Clean up ✓, straighten ✓ + Powder ✓

Signature: David Beatty

Date: 17/12/12 Lic. No. / SCA ~~AD 73-04~~ 05

In Process

Form# 20.E.03 Rev. 1 24 April 2014

WANDERING WHEELS
25 JUNE 2019

Aero Design

Parts Distribution Sheet

Description: AS350 RH Beams

WO# 2017-104

From PO or WO #	Quantity	Description	Part Number	For WO #
2017-104	1	RH Aft Beam	78633-01-01	
17061	1	Grip Tape	3M Safety Walk	

1. Approving Civil Aviation Authority/Country	2. AUTHORIZED RELEASE CERTIFICATE FORM ONE	3.Form Tracking No.
Transport Canada		2019-0266

4. Organization Name and Address	5. Work Order/Contract/Invoice
AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3	None

6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
1.	Aft RH Beam	78633-01-01	1	WO 2017-104	New

12. Remarks

Certification data: TCCA STC SH08-16

13a. Certifies that the items identified above were manufactured in conformity to:

☒ Approved design data and are in condition for safe operation.

☐ Non approved design data specified in block 12.

~~14a.~~ ☐ CAR 571.10 Maintenance Release

☐ Other regulation specified in block 12

Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the *Canadian Aviation Regulations*.

13b. Signature	13c. Approved Organization Number	~~14b. Signature~~	~~14c. Approved Organization Number~~
Jason Rekve	AMF 73-04		
13d. Name	**13e. Date (dd/mmm/yyyy)**	~~14d. Name~~	~~14e. Date (dd/mmm/yyyy)~~
Jason Rekve - AD01	11 Aug 2019		

Installer Responsibilities

This certificate does not constitute authority to install.

Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.

Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.

BLACK COMB

Aero Design Ltd.
9888 A Malaspina Rd. Powell River, BC, V8A 0G3
Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

In Process

Remarks

DEMONSTRATION PART RETURNED
NO RELEASE ISSUED

Inspected - No defects noted [signature] AD01
11 Aug 19

Aero Design Ltd.
9888 A Malaspina Rd. Powell River, BC, V8A 0G3
Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: AS350 AFT ~~LH~~ RHJC BEAM No. of pieces: 1

Manufacturer: AERO DESIGN LTD.

Part No.: 78633-01-02 Serial / Batch No.: NSN

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2017-~~103~~ 104 JC

Remaining Tasks to be Performed: INSPECT ✓

Signature:

Date: 30 JULY 2019 Lic. No. / SCA AD 02

In Process

BLACKCOMB

11 AUG 2019

Aero Design

Parts Distribution Sheet

Description: AS350 RH Beams

WO# 2017-104

From PO or WO #	Quantity	Description	Part Number	For WO #
2017-104	1	RH Aft Beam	78633-01-01	
17061	1	Grip Tape	3M Safety Walk	